



DURMAT® FD 250 K

Flux-Cored Wire for Hardfacing

DIN EN 14700
DIN 8555

T Fe9-250-KNP
MF7-250-KNP

General characteristics:

DURMAT® FD 250 K is a Flux-Cored Wire of the Mn-Cr-type. The complete austenitic weld material shows high plasticity and can be applied as a buffer layer. Deposits can be work hardened up to 500 HB, are stainless and non-magnetic. The deposits resist high shrinkage and impact stresses.

Application:

Repair of manganese steel buckets and shovels, high tensile tools and dies, clutches, crane wheels, earthmoving undercarriage parts, gear wheels, etc.

Typical chemical composition (all weld metal in wt.-%):

C	Si	Mn	Cr	Mo	Fe
0.45	0.40	16	13.5	0.30	Bal.

Typical physical characteristics:

Hardness (all weld metal): 220 - 250 HB when deposited
450 - 500 HB when work hardened

Sales units:

Product types: MIG, OA, SAW
Spool BS 300 (DIN EN ISO 544): 15 kg
Spool B 450 (DIN EN ISO 544): 25 kg
Drum: 150/250 kg

Welding recommendation:

Shielding gas (DIN EN ISO 14175): M13, M21, M23

Ø [mm]	Ø [inch]	Amperage [A]	Voltage [V]
1.2	.0045	140-200	20-25
1.6	1/16	180-220	20-26
2.0	5/64	220-250	22-26
2.4	3/32	260-300	24-27
2.8	7/64	300-340	27-28
3.2	1/8	360-500	30-32

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