

# CORODUR® 600TiC

## CLASSIFICATION:

DIN 8555      DIN EN 14700  
MF 6-60-GP    T Fe 8-60-GP

## GENERAL CHARACTERISTICS:

**CORODUR 600TiC** is a C-, Cr-, Ti- and Mo-alloyed flux-cored wire for parts that are exposed to high abrasive wear in combination with impact stress. It is perfectly suited to Drill-Pipe hardbanding and belongs to a most successful class of "crack-free" weld deposits for this specific application. The micro structure of the deposit is martensitic with evenly distributed Titanium Carbides. Specially formulated for drill pipe boxes to protect the drill pipe while defending against casing wear. Can also be used for mining applications such as crusher rolls.

## APPLICATION:

Drill-pipe tool joints, cement crusher rollers, hammers, all types of crushing units

## TYPICAL ALL WELD METAL ANALYSIS %

C	SI	Mn	Cr	Ti	Mo
<2	<2	~1.5	7,0	5-6	~1.5
Co	Nb	V	W	Fe	other
-	-	-	-	-	-

## HARDNESS:

57 – 60 HRC (up to 3 layers with maximum hardness achieved in 3<sup>rd</sup> layer)

## WELDING PARAMETERS:

Measurement	Voltage	Ampere
1.6mm	20-26	160-220
2.0	22-26	220-260

## FORMS OF DELIVERY:

Kind	Coil BS 300	Coil B 450	Pay off pack	-
Weight	15kg	25 kg	300kg	-

## WELDING RECOMMENDATION:

The surface to be hard faced should be clean and free of rust, scale or grease and other contamination, preferably by grinding or grit blasting.

Care to remove interlayer slag.

Old deposits can be over-welded but must be free of dirt and grease.

Please observe all appropriate safety regulations in force. The technical information given in this data sheet reflects the present state of knowledge. They do not form part of any sales contract as guaranteed properties of the delivered materials. Our delivery and sales conditions apply to all contracts included.

CORODUR Fulldraht GmbH has a continuous program of product development and, in this context, reserves the right to alter specifications without prior notice.