CARBODUR 65

Standards

DIN 8555	E 10-UM-65-GRZ
AWS A5.13/21	EFeCr-A1

Approvals ---

Characteristics

CARBODUR 65 is a heavy coated high efficiency hardfacing electrode with 240 % recovery.
The weld metal has a ledeburitic structure with an alloy containing carbides of different kinds.
The electrode is used for hardfacing of parts subject to strong abrasive wear, friction also at high temperatures. The weld metal structure is ledeburitic, the alloy contains carbide forming elements of different kinds.
CARBODUR 65 provides extremely high resistance to abrasion also at temperatures up to 600°C.
The weld metal is nearly free of slag.
A buffer layer of CARBO 4370 MPR is recommended prior to surfacing on old claddings.

Typical applications

CARBODUR 65 is mainly used for hardfacing on conveyor worms, clinker crushers, blast furnace bells, grates in mineral dressing equipment, especially where live coal and slag are treated

Operating temperature From room temperature up to + 600° C

Hardness of all-weld metal (typical values)

HRc	HRc at 400°C
ca. 64	ca. 45

Weld metal analysis (typical, wt. %)

C	Si	Cr	Mo	Nb	W	V
4,5	1,2	24	6	6,2	2	1

Current = + / ~ 50 V

Welding positions PA, PB

Rebaking 1 h, 150°C + / - 10 °C (if required)

Flux-cored wire equivalent

CARBO F- 65

Dia./Length	Amperage (A)	Pcs./ packet	Pcs./ carton	kg / 1000	kg / packet	kg / carton
2,5 x 350	80 - 110	126	504	39,7	5.0	20.0
3,2 x 350	120 - 140	75	298	67,1	5.0	20.0
4,0 x 450	140 - 180	46	184	130,7	6.0	24.0
5,0 x 450	180 - 230	29	117	204,3	6.0	24.0

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