CARBODUR 68 T

Standards	DIN 8555	E 10-UM-70-GTRZ
	DIN EN 14700	E Fe14
	AWS A5.13 / 21	EFeCr-A1

Approvals ---

Characteristics Thickly coated high efficiency electrode with approx. 210 % recovery.
The weld metal structure is ledeburitic, the alloy contains carbide forming elements of different kinds.
CARBODUR 68 T is mainly used for applications where parts are subject to strong abrasive wear since the deposited alloy is highly resistant to abrasion, also when exposed to high temperatures.
Smooth fusion, almost slag-free deposit.
Prior to surfacing on old hardfacing layers a buffer layer with CARBO 4370 MPR is recommended.

Operating temperature From room temperature up to 300° C

Typical applications CARBODUR 68 T is mainly used for hardfacing on equipment in sintering plants, steel mills, coke oven plants, coal excavation and overburden removal, etc.

Mechanical properties of all-weld metal

(typical values)

Hardness HRC
approx. 69

Weld metal analysis (typical, wt. %)

C	Si	Cr	Others
4	2	28	ca. 4

Current = + / ~ 50 V

Welding positions PA, PB

Rebaking 1 h, 130 °C + / - 10 °C (if required)

Flux-cored wire equivalent CARBO F- 68

Dia./Length	Amperage (A)	Pcs./ packet	Pcs./ carton	kg / 1000	kg / packet	kg / carton
2,5 x 350	80 – 110	183	733	27,3	5,0	20,0
3,2 x 450	110 – 140	101	405	59,3	6,0	24,0
4,0 x 450	140 – 180	67	267	89,8	6,0	24,0
5,0 x 450	180 – 230	43	171	140,3	6,0	24,0

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