

## XP DUR 600 (Seamless)

HARDFACING 

### CLASSIFICATIONS

EN ISO 14700

T Fe8

### KEY FEATURES AND APPLICATIONS

- Seamless metal cored wire designed for wear-resistant hardfacing applications.
- Provides excellent resistance to abrasion, impact and edge retention.
- Typical diffusible hydrogen content is <3.0 ml 100 g. Guaranteed for the total processing time <4.0 ml 100 g.
- This alloy deposits a martensitic structured weld-metal.
- Commonly used in hardfacing applications within the earthmoving, quarrying and agricultural sectors.

### CHEMICAL COMPOSITION OF ALL-WELD METAL %

	C	Cr	Mn	Mo	W	V	Nb	Fe
MIN	0.2	5	-	-	-	-	-	Bal
MAX	2	20	3	5	2	2	10	

Single values are maximum values according to EN ISO 14700

### MECHANICAL PROPERTIES OF ALL-WELD METAL - TYPICAL VALUES

Hardness - Third Layer

57 - 62 HRC

Test data for mechanical properties are not guaranteed since actual as welded conditions depend on numerous variables

### OPERATING DATA

Shielding Gases	Polarity
EN ISO 14175 - M21	DC+

### WELDING PARAMETERS

Diameter	Current (A)	Voltage (V)
1.2mm	110 - 300	16 - 32

Depending on the base material, preheating in the range of 150°C to 300°C may be required

### PACKAGING AND AVAILABLE SIZES

Part Number	Diameter (mm)	Spool	Weight (kg)	Pallet Qty
XP20410	1.2	S200	5	200
XP20411	1.2	BS300	15	72