

ROBODUR K 250-G

CLASSIFICATION

EN 14700 T Fe1

DESCRIPTION

- Seamless copper coated tubular wire for gas shielded metal arc hardfacing
- Excellent weldability
- Surfacing or rebuilding parts subjected to high compression stresses and high impact

APPLICATIONS

Robodur K250-G, up to Ø 1.6 mm, is suitable for downhand as well as for positional welding by adapting transfer mode and welding parameters as for solid wires

Examples

Rebuilding and buffering of forged or rolled mechanical components: transmission shafts, rolls or chocks for steel making, roller bearing seats, rollers for gantry cranes, gear teeth, forging tools and dies.

TYPICAL ALL-WELD METAL ANALYSIS

| C | Mn | Si | Cr | Mo | Fe |
|------|------|------|------|------|------|
| 0.10 | 1.50 | 0.70 | 1.50 | 0.20 | Rest |

Structure: bainite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-Layer deposit:

As welded 250 HB

CONDITIONS OF USE

| Current type | Shielding gas |
|--------------|-----------------------|
| DC (+) | M12 / M13 / M20 / M21 |

OPERATING CONDITIONS

| Diameter [mm] | Amperage [A] | Voltage [V] | Stick-out [mm] | Gas flow [l/min] |
|---------------|--------------|-------------|----------------|------------------|
| 1.2 | 100 - 300 | 24 - 32 | 12 - 25 | 10 - 20 |

| Diameter [mm] | Amperage [A] | Voltage [V] | Stick-out [mm] | Gas flow [l/min] |
|---------------|--------------|-------------|----------------|------------------|
| 1.6 | 150 - 300 | 24 - 32 | 12 - 25 | 10 - 20 |
| 2.0 | 200 - 400 | 24 - 32 | 12 - 30 | 10 - 20 |
| 2.4 | 250 - 450 | 24 - 32 | 12 - 30 | 10 - 20 |

Recovery: > 95 %

WELDING POSITIONS

Robodur K250-G, up to Ø 1.6 mm, is suitable for downhand as well as for positional welding by adapting transfer mode and welding parameters as for solid wires

STANDARD DIAMETERS (mm)

1.2, 1.6, 2.0, 2.4

Other diameters: please consult us

PACKAGING

| Diameter | 2.4 mm | | 2.4 mm |
|---------------------------------|----------------|--------------|--------------|
| Standard packaging [EN ISO 544] | Spool : BS 300 | Coil : B 450 | Drum |
| Weight | 15 kg | 25 kg | Up to 330 kg |