Technical Data Sheet

ROBODUR K 600

Low and medium alloyed steel -> Seamless copper coated metal cored wire for Gas Metal Arc Welding (GMAW)

1 GENERAL INFORMATION

EN 14700 : T Fe2

- Martensitic deposit containing finely dispersed hard carbides
- Ensures an optimal balance between abrasion, friction and impact resistance
- Abrasion resistance is maintained at service temperatures up to 450°C
- Deposition rate increased by up to 20% when compared to solid wire, with unique welder appeal
- Wire does not pick up moisture, and the wire feeding properties are excellent
- Designed for welding in flat, horizontal, horizontal-vertical and vertical-up positions

Bucket teeth, bucket lips, bulldozer blades, crusher jaws, scraper blades, chutes, pump housings, conveyor screws, slide plates, gear teeth, crusher hammers, drilling bits, ploughshares, reamers, etc.

2 ALL WELD METAL PROPERTIES

CHEMICAL ANALYSIS [%]

C	Mn	Si	Cr	Mo
0.5	1.2	0.6	5.7	0.8

HARDNESS

57-62 HRC (as welded, three-layers)

Direct current electrode negative polarity (DC-) reduces dilution and favours high hardness

3 RECOMMENDED WELDING PARAMETERS

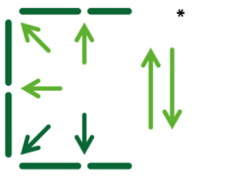
Diameter [mm]	Welding Position	Polarity	Current [A]	Voltage [V]	Stick-out [mm]
1.2	PA / 1G or 1F	DC+	150 - 250	24 - 28	20 ± 5
1.6	PA / 1G or 1F	DC+	200 - 300	24 - 28	20 ± 5

WELDING PROTECTION

Shielding gas (EN ISO 14175)

- M12 (Ar + 0.5% ≤ CO2 ≤ 5%)
- M13 (Ar + 0.5% ≤ O2 ≤ 5%)
- M20 (Ar + 5% < CO2 ≤ 15%)
- M21 (Ar + 15% < CO2 ≤ 25%)

WELDING POSITION



*Out of position welding also possible using short circuit or pulsed arc modes of transfer

YouTube TUTORIAL VIDEO

Video Link

4 PACKAGING OPTIONS

Diameter [mm]	1.2 - 1.6
Standard packaging (EN ISO 544)	BS 300 spool
Weight [kg]	15

Other packaging requirements: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.