

# Technical Data Sheet

## ROBODUR K CERAMIC



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

### 1 GENERAL INFORMATION

EN 14700 : T Fe8

- Martensitic weld metal contains finely dispersed hard carbides
- Ensures an optimal balance between abrasion, friction and impact resistance
- Specially designed for hardfacing new or worn ceramic moulds
- No moisture-pick up with excellent wire feeding properties
- Deposition rate increased by up to 20% when compared to solid wire, with unique welder appeal
- Designed for welding in flat, horizontal, horizontal-vertical and vertical-up positions



New or worn ceramic moulds, etc.

Abrasion	████	████	████	□□	□□
Impact	████	████	████	████	████
Metal-metal	████	████	████	□□	□□
Corrosion	████	□□	□□	□□	□□
Temperature	████	████	████	□□	□□

### 2 ALL WELD METAL PROPERTIES

#### CHEMICAL ANALYSIS [%]

C	Mn	Si	Cr
0.35	0.6	2.4	9.4

#### HARDNESS

55-60 HRC (as welded, three-layers)

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

### 3 RECOMMENDED WELDING PARAMETERS

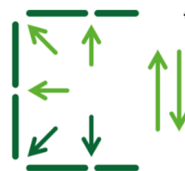
Diameter [mm]	Welding position	Polarity	Intensity [A]	Voltage [V]	Stick-out [mm]
1.2	PA / 1G or 1F	DC+	150 - 250	24 - 28	20 ± 5
1.6	PA / 1G or 1F	DC+	200 - 300	24 - 28	20 ± 5

### WELDING PROTECTION

Shielding gas (EN ISO 14175)

- M12 (Ar + 0.5% ≤ CO<sub>2</sub> ≤ 5%)
- M13 (Ar + 0.5% ≤ O<sub>2</sub> ≤ 5%)
- M20 (Ar + 5% < CO<sub>2</sub> ≤ 15%)
- M21 (Ar + 15% < CO<sub>2</sub> ≤ 25%)

### WELDING POSITION



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

### 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