

Corthal[®] 65 OA

Self-shielded Flux-cored Wire Electrode



Corthal[®] 65 OA is a C-, Cr-, Nb-, Mo-, V- and Tu- alloyed, self-shielded flux cored wire electrode, which forms extremely hard carbides. This alloy is used for hardfacing against extremely mineral wear. The deposit retains its wear resistance up to 650°C but the coating should be limited to two layers.

Typical All-Weld Metal Analysis [%]

C	Si	Mn	Cr	Mo	Nb	V	W	Fe
4,3	0,9	0,1	19,0	5,0	5,5	0,8	1,4	Basis
5,4	1,8	0,2	22,5	7,0	7,0	1,2	2,1	

Min./Max. über alle Lieferformen

Hardness

20 °C	400 °C	650°C
63 – 65 HRC	61 HRC	< 57 HRC

Microstructure

Austenitic with primary carbides and eutectic M_7C_3 - carbides as well as globular Nb-, Mo-, V- and W- carbides

Available Diameters and Welding Parameters

Diameter	1,2	1,6	2,0	2,4	2,8	3,2	4,0
Ampere	100	120	160	260	300	350	380
	220	280	280	320	380	420	450
Volt	20	24	26	27	28	29	30
	24	28	28	29	31	32	33

Forms of Delivery

Spool B / BS 300	13 – 15 kg	EN 759
Spool B 450	25 – 27 kg	EN 759
Big Spool S 760	ca. 250 kg	EN 759
Drums	ca. 150 kg or 250 – 300 kg	

- **EN 14700**
T Fe 16-65-GZ
- **DIN 8555**
MF-10-65-GZ

Sinter breaker

Grill bars

screens and plates in hot sintering area

Mixer blades

Blast furnace bells

Chutes and liners

Corodur Verschleiss-Schutz GmbH

Wolfsburgstraße 31a
06502 Thale
Deutschland



Revision 01/2019