

Technical data sheet <small>011121MBA</small>	Cored welding wire ROBODUR K 250-G	
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CLASSIFICATION

EN 14700: T Fe1

DESCRIPTION

- Seamless high fill copper coated tubular wire for semi-automatic gas shielded hardfacing
- Low alloy bainitic deposit
- Unique welder appeal
- Deposition rate increased by up to 20% when compared to solid wire
- Wire does not pick up moisture, the wire feeding properties are excellent
- Designed for welding in horizontal, horizontal-vertical and vertical-up positions

APPLICATIONS

ROBODUR K 250-G is used for rebuilding of worn hardened steel parts subject to high compressive stresses and heavy impacts. It can also be used as a buffer layer on ferritic steels before hardfacing with wires providing higher abrasion resistance.

Examples

Transmission shafts, gear teeth, conveyor chains, wheels of rolling bridges, bearing tracks, forgings and dies etc.

TYPICAL ALL-WELD METAL ANALYSIS

C	Si	Mn	Cr	Mo
0.07	0.5	1.3	1.6	0.2

Microstructure: bainite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: As welded, 3-layer deposit on mild steel: 250 HB

CONDITIONS OF USE

Current type	Shielding gas
DC-, DC+ or pulsed	M12: Ar + 0.5 – 5 % CO ₂
	M13: Ar + 0.5 - 3% O ₂
	M20: Ar + 5 – 15 % CO ₂
	M21: Ar + 15 – 25 % CO ₂

OPERATING CONDITIONS

Diameter [mm]	Current [A]	Voltage [V]	Stick-out	Gas flow rate
1.2	110 - 300	16 - 32	12 – 25 mm	10 - 20 l/min.
1.6	130 - 350	16 - 32	12 – 25 mm	10 - 20 l/min.

Direct polarity (DC-) reduces dilution and favours high hardness. It can be useful in special circumstances such as hardfacing on edges.

Recovery: 98%

WELDING POSITIONS

ROBODUR K 250-G is suitable for both downhand and positional welding by adapting transfer mode and welding parameters as for solid wires.

PACKAGING

Diameter	1.2 mm	1.6 mm
	EN ISO 544 – ASME II C SFA-5.2 M	
Spool type	BS300	
Weight	15 kg	

Other packaging and other diameters: 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.