

# PRODUCT DATA SHEET

## Duracor 59-O

Duracor 59-O is a self-shielded flux cored wire, which deposits a weld metal containing chromium carbides in an austenite carbide weld matrix. It provides excellent abrasion resistance. Normally a deposit thickness of two layers is recommended to prevent weld cracking, but up to five layers may be applied with the correct procedure.

### Applications

Duracor 59-O is suitable for the hardfacing of sugar cane hammers and knives, mining machinery, buckets, dipper teeth, pulveriser rings, coal crushers and other parts subject to severe abrasive wear.

### Classifications

DIN	8555	MF6-GF-60-G (nearest)
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### Typical Chemical Analysis (All weld metal)

% Carbon	4,9	% Silicon	1,0
% Manganese	1,5	% Chromium	29,5

### Typical Mechanical Properties

Abrasion Resistance	Excellent
Impact Resistance	Poor
Machinability	Grinding is difficult
Flame Cutting	Cannot be flame cut
Thickness	3-5 layers max
Microstructure	Massive chrome carbide in an austenite-carbide matrix

Deposit will relieve check crack

### Typical Hardness

Layer	1020 Steel
1	54 HRc
2	57 HRc
3	60 HRc

### Welding Data

(DC+)

Diameter (mm)	Current		Electrode Stick Out
	Amps (A)	Volts (V)	
2,8	400 - 450	26 - 29	38 - 51

### Packing Data

Diameter (mm)	Item Number	Spool Mass (kg)	Spool Type
2,8	W071728	25	Spool
2,8	W071729	250	Drum

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