

# CORDIFF 814

## CHARACTERISTICS:

CORDIFF 814 is a flux cored wire electrode, depositing a rich Cr-Ni-Mo-V weld metal containing lower carbon content. Excellent for building up the working face of composite hot forging dies, both large as well as small. The deposit has excellent wear resistance at elevated temperatures, very good hot strength and thermal shock resistance. The deposit shows fairly good machinability. The as welded hardness is 44 – 48 HRc. Preheating of the base metal is beneficial.

## APPLICATIONS:

Thermal shock and heat resistant flux-cored wire electrode for maintenance and to increase the service life of hot working tools, e.g. hot forging dies, etc.

## Hardness:

<b>44 - 48 HRC</b>
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## WELDING PARAMETERS:

DIA. (mm)	VOLTAGE	AMPS
1.6	24 – 26	180 – 220
2.0	25 – 27	220 – 250
2.4	25 – 27	260 – 300
2.8	26 – 28	300 - 340

## STANDARD PACKING :

Spool = 15 kgs(± 1kg)    Spool = 25 kgs(± 1kg)    Drum = 200 - 250kgs

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