

DUROXITE®

OVERLAY WELDING CONSUMABLES



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**FIGHTS WEAR,
GUARANTEED**

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Duroxite® overlay products can add weeks, months, even years of trouble-free operations to your most extreme wear situations. Duroxite® is particularly well suited to fighting sliding wear from exceptionally hard particles such as minerals containing quartz.

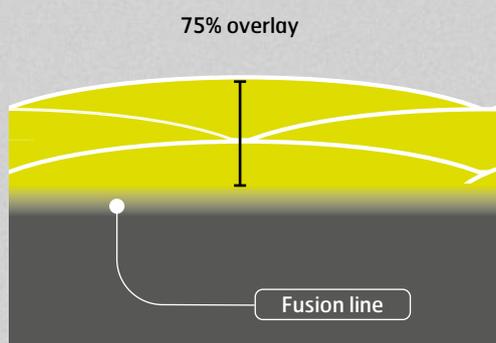
OVERLAY WIRE AND ELECTRODES

Duroxite® welding consumables are highly suitable for all kinds of wear challenges, welding positions, abrasiveness of the material and operating temperatures. Apart from the wires and electrodes with different properties, Duroxite® products are also available as plates, pipes and pins.

See the full range of products at duroxite.com

	WIRE				ELECTRODE
	DUROXITE® 100 WIRE	DUROXITE® 200 WIRE	DUROXITE® CR-ZERO WIRE	DUROXITE® AP WIRE	DUROXITE® AP ELECTRODE
DESCRIPTION	A flux cored open-arc wire for hardfacing components subject to sliding wear applications.	A flux cored open-arc wire for hardfacing components subject to severe sliding wear applications.	A wire suitable for overlay welding situations where it is difficult to protect the welder from the emission of hexavalent chromium smoke.	A wire with properties that make it suitable for all-position (AP) welding, including flat, horizontal, vertical and overhead welding.	An electrode with properties that make it suitable for all-position (AP) welding, including flat, horizontal, vertical and overhead welding.
PROPERTIES	Chemical composition (wt. %): 4.7 C, 0.2 Mn, 0.6 Si, 27.0 Cr, balance Fe Surface hardness: Three-layer deposit on mild steel 60-62 HRC ASTM G65-Procedure A weight loss: 0.18 g max.	Chemical composition (wt. %): 5.3 C, 0.5 Mn, 0.2 Si, 22.0 Cr, 6.5 Nb, balance Fe Surface hardness: Three-layer deposit on mild steel: 62-67 HRC ASTM G65-Procedure A weight loss: 0.12 g max.	Chemical composition (wt. %) 0.6 C, 2.3 Mn, 1.5 Si, 2.4 Ni, 4.0 B, balance Fe Surface hardness Two-layer deposit on mild steel: 65-69 HRC ASTM G65-Procedure A weight loss: 0.18 max.	Chemical composition (wt. %) 0.5 C, 1.3 Mn, 0.6 Si, 7.0 Cr, 0.6 Mo, balance Fe Surface hardness Three-layer deposit on mild steel: 56-60 HRC	Chemical composition (wt. %) 0.5 C, 0.7 Mn, 0.6 Si, 5.5 Cr, 1.3 Mo, balance Fe Surface hardness Three-layer deposit on mild steel: 56-60 HRC
STANDARD DIMENSIONS	1.2 mm (0.045") 1.6 mm (1/16") 2.8 mm (7/64")	1.2 mm (0.045") 1.6 mm (1/16") 2.8 mm (7/64")	1.6 mm (1/16") 2.8 mm (7/64")	1.6 mm (1/16")	4.0 mm (5/32")
TYPICAL APPLICATIONS	Loader bucket liners, bucket lip and side shrouds, jaw shrouds, heel pads and dewatering conveyors, coal discharger chutes.	Screen plates, loader bucket liners, feeding systems for ball mills, loader bucket liners, bucket lip shrouds, bucket side shrouds, chutes, liner plates and skip liners, cement furnace components, sinter plant parts, fan blades, mixer blades, crews, gyratory mantles, coal and cement pulverizer rolls, raw material crushing components, molding panels, coal discharger chutes.	Mixer shafts, impellers, buckets, shovels, transport screws, and crushers for the concrete industry.	Bucket teeth, tillage tools, bucket lips, bucket sides, cutting edges, sand dredge equipment, dragline buckets, conveyor chutes, grizzly bars, screw flights, metal shredders, sliding metal parts, tire shredder knives, extruder screws, tamper feet, churn drills, muller tires. Especially applicable for all-position welding and re-instating of hardfacing sealing runs on clad wear plate fabrications.	Bucket teeth, tillage tools, bucket lips, bucket sides, cutting edges, sand dredge equipment, dragline buckets, conveyor chutes, grizzly bars, screw flights, metal shredders, sliding metal parts, tire shredder knives, extruder screws, tamper feet, churn drills, muller tires. Especially applicable for all-position welding and re-instating of hardfacing sealing runs on clad wear plate fabrications.

GUARANTEED OVERLAY THICKNESS, GUARANTEED OVERLAY PROPERTIES



Duroxite® overlay plates and pipes are delivered with an overlay thickness guaranteed within $\pm 10\%$. This is consistent throughout the material and between individual plates and pipes.

The wear properties of Duroxite® are also guaranteed throughout the overlay down to 75% of the overlay thickness.

The remaining 25% of overlay is the transition layer necessary to maintain good bonding to the base material.