



elektrode jesenice d.o.o.

**Classification:**  
 DIN 8555 : MSG 6-GF-C1-60 GP/  
 MSG 6-GF-M21-60 GP  
 EN 14700 : T Fe 2

# FILTUB DUR 16

## Description and application:

FILTUB DUR 16 is metalcored medium alloy flux-cored wire recommended for highly wear resistant surfacing. The deposit is tough, free of cracks and porosity and therefore is highly resistant to deformation and impact.

On base material with low weldability is recommended depositing a buffer layer with FILTUB 12B or FILTUB DUR 3. The preheat and interpass temperature must be at least 200°C. Weld deposit can be machined only by grinding.

Suitable for surfacing parts of: mixer blades and vessels, grab and bucket teeths, crusher hammers and jaws, etc .

## Base materials:

Steels
Steel castings

## Heat treatment:

### Type of wire :

metalcored

### Welding current:

DC + / (-)

### Welding positions:



### Shielding gas : ( EN 439 )

CO<sub>2</sub> , M 21  
 consumption : 12 - 18 l / min

## Typical weld metal properties:

### Chemical composition, wt %:

C	Si	Mn	Cr	Mo
0,45	0,60	1,60	5,50	0,80

### Mechanical properties:

Hardness: 56 - 60 HRC

The hardness of the deposit depending on the relevant welding conditions and the chemical composition of the base metal .

## Welding and packing data:

Approvals:	Welding parameters				Packing
	φ mm	Current A	Arc voltage V	Wire feed rate m / min	
	1,2	130 - 250	23 - 28	2,5 - 8,0	K 300 , D 300 lay to lay weight : approx. 15 kg
	1,4	180 - 340	24 - 30	3,0 - 8,0	
	1,6	220 - 420	26 - 32	4,0 - 9,5	