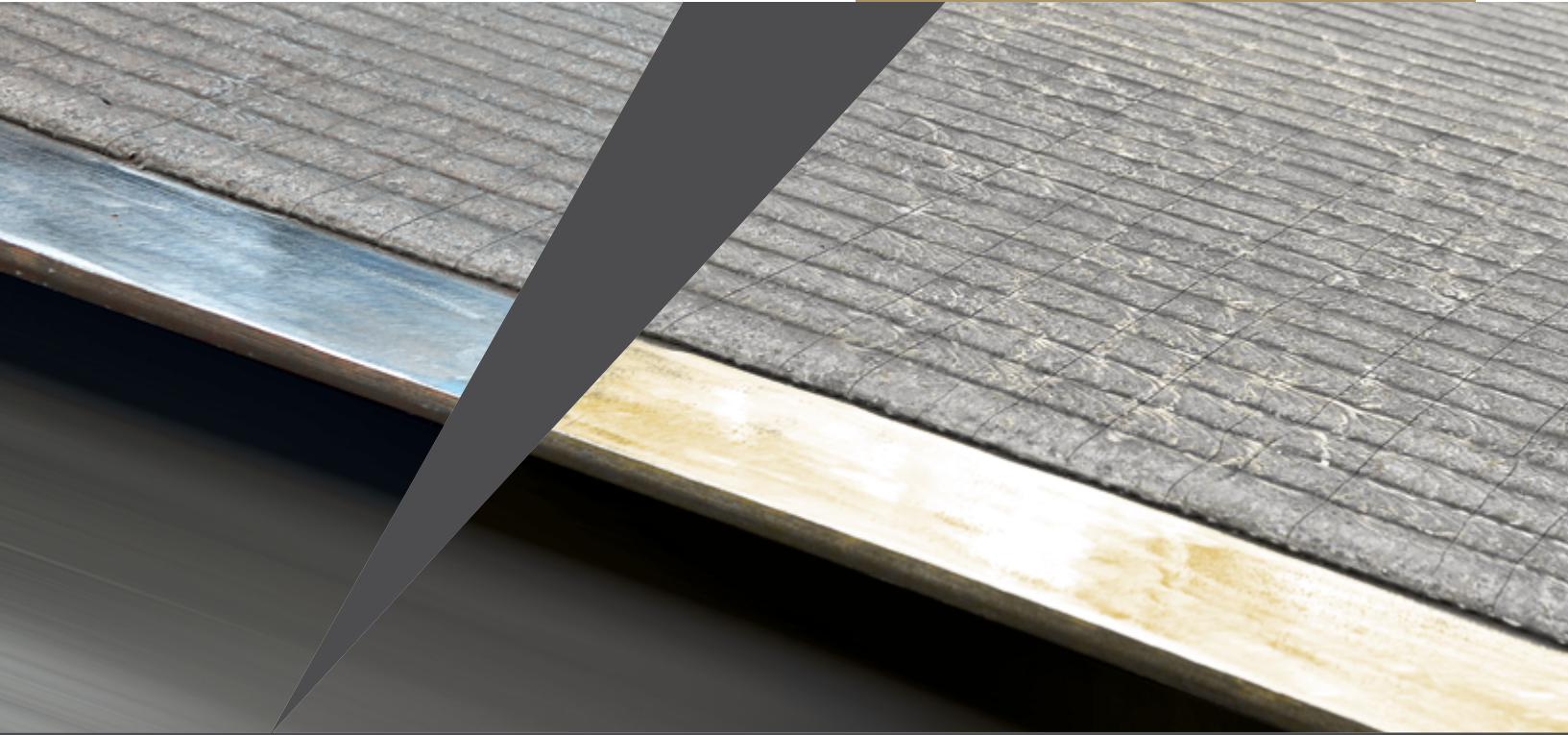




DATA SHEET **EURODUR®** **1680 N**

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Special alloy for the glass industry



PLANNING & CONSULTING



From consulting and system engineering to the finished product.

QUALIFIED CONSULTANTS



We have the right specialist for every challenge.

CONSTRUCTION & PRODUCTION



Your order is produced with our cutting edge technology in best quality with utmost accurateness.

DELIVERY / ASSEMBLY



Flexible and dependable – including assembly on-site.

EURODUR® always sets focus on innovative products. Constant enhancements are achieved by closely working together with you as our client. Only together your individual needs and challenges can be solved. Hundreds of active EURODUR® clients are able to verify this, especially in the field of cement, mining, steel and recycling industry.

Every single EURODUR® production facility is equipped with the most advanced technology. Production is computer controlled to reproduce optimum material performance even with varying material thickness. Our intense research work lead us (for instance) to optimize the cooling cycle to enhance the hardening phase. Constant improvement and quality control guarantee for optimum performance.

Special alloy for the glass industry

PRODUCT INFORMATION

Production Technology	The EURODUR [®] Composite plates are produced with highalloyed filler wire in an OpenArc-welding process. A high share of carbid-alloyed elements in the filler wire, combined with our self developed cooling technology of our welding tables, guarantee for an optimized homogeneous distribution of hardening material in the coating area and a minimum mixture with the substrate material
Technical Data	EURODUR [®] 1680N is a self-shielded flux-cored wire for highly wear resistant, low-nickel overlay weldings. Due to the high proportion of chrome, silicon and boron in combination with a nickel content of maximum 0,04% this special alloy provides greatest protection in glass manufacture against unwanted nickel sulphide inclusions.
Substrate to highly wear resistant coating	Substrates, from S235JR2 up to high-alloy materials. Standard thickness.
Material Thickness of base material	5, 6, 8 and 10 mm – more upon request.
Dimensions (coated area)	Deliverable format sizes: Small format: 850 x 1850 mm Medium format: 1100 x 2350 mm Large format: 1350 x 2850 mm Special formats up to max. 1850 x 3800 mm on request
Coating thicknesses	Single Layer and Double Layers.
Coating hardness	At normal temperature (20 °C), EURODUR [®] 1680 N reaches a hardness of up to 62 HRC +/- 3. Operating temperature up to 500 °C. Hardness measurement with test piece DIN 32525-4.
Applications	EURODUR [®] 1680N is especially suited for extremely heavy wear by mineral materials. The weld metal is corrosion-resistant.
Successful application examples for EURODUR[®] 1680 N	Wear plates, mixing blades, scrapers, crushing tools, mixer arms, conveying screws, ect.

Sales units:

Product types:	0A
Spool BS 300 (DIN EN ISO 544):	15 kg
Spool B 450 (DIN EN ISO 544):	25 kg
Drum:	150/250 kg

Welding recommendation:

ø [mm]	Amperage [A]	Voltage [V]
1.6	120-220	20-26
2.0	220-300	22-26
2.4	260-320	24-27
2.8	300-360	26-28