

FLUX CORED WIRE

KOY 260

FLUX CORED WIRE FOR COATING CERAMIC TILES

CHARACTERISTICS

KOY 260 flux cored wire was expressly formulated for the coating of every kind of steel mould edge in the ceramic tile industry.

A characteristic of the deposit is a good resistance to abrasion and good weldability both on new or restored tiles.

With this wire you may weld either single or overlaid layers without any risk of cracks.

Wear resistance comparison tests made by our laboratory, pointed out weight losses lower than 1/4 compared to KOY CR MO V wire (17% Cr HRC 57) and than 1/3 compared to KOY 223 wire (9% Cr 3% Si HRC 60).

For this reason you can rely on a longer working cycle of respectively 25% and 30% as to the above mentioned solid wires.

KOY 260 flux cored wire workability on tool machines shows the same limited difficulties as the KOY CRMOV and KOY 223 ; in comparison with these two wires you won't notice any higher wear of tool shears.

CHEMICAL ANALYSIS

C Cr Mo Si Mn Fe

MECHANICAL CHARACTERISTICS

Durezza HRC 57÷62

The hardness can vary slightly according to the chemical composition of the base material, the welding parameters, the shielding gas used, the penetration and the cooling speed of the deposition.

KOY **COMMERSALD**
MATERIALI E IMPIANTI PER SALDATURA

DATA SHEET



GL



COMMERSALD

A company with a Quality Assurance System certified according to:
UNI-EN-ISO 9001:2000
Certificate N° 141

Codice N° 260-english
Rev. 4
Data 15.02.06
Approvazione RRT - RSQ

CERAMIC TILES COATING

APPLICATIONS

Coating of new and restored ceramic tiles, of refractories and other applications where the metal wear is typical in the presence of pulverized abrasive.

TECHNICAL USE

Welding must be done with a Ar-CO₂ shielding gas. Welding parameters have to be adjusted according to the bead shape that you want to obtain (in general, the current intensity is lower compared to that of a solid wire of the same diameter).

KOY 260 wire efficiency 91%.

Slag residuals present on the deposited bead are easily removable by simply brushing ; it's always better to carry it out on the piece after cooling.

COMPLEMENTARY PRODUCTS

All the data and characteristics of the product mentioned on this data sheet represent a first indication for the choice of the most apt solution to every specific welding problem.

Our technical staff can give you a complete outline on every one of the 500 products available in stock and may give you advice on possible alternatives.

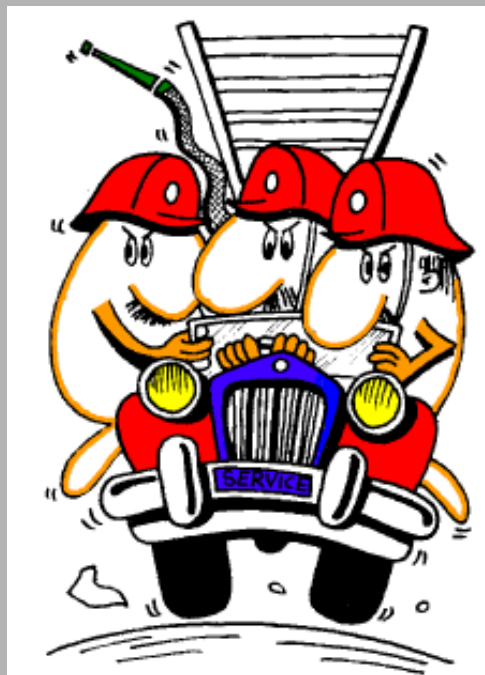
TECHNICAL ASSISTANCE

Every single KOY® product is assisted by our sales staff who, together with the technicians and metallurgical consultants, may give you advice on the most apt method and processes to use.

Our laboratory is equipped to make trials and new experiences as well as quality controls and tests. The technical office is able to supply certificates of analysis upon request.

PACKAGING

Metallic spools type K 300 , approximate weight Kg 15; Ø available 1,2 - 1,6 mm.



COMMERSALD

Via Bottego, 245 - 41126 Modena
Tel 059-348411 - Fax 059-343297
<http://www.commersald.com>
e-mail: info@commersald.com

Office in Milan:
Viale E de Marchi, 4 - 20125 - Milano
Tel 02-67382348 - Fax 02-66710308

Commersald Impianti srl :
Via Labriola, 39 - 41123 - Modena
Tel 059-822374 - Fax 059-333099