Technical data sheet 011121MBA	Cored welding wire # CHROMECORE 414-G	Welding Alloys

CLASSIFICATION

EN 14700: T Fe7

DESCRIPTION

- Metal-cored tubular wire for gas-shielded metal arc hardfacing
- Martensitic stainless steel deposit
- Deposit offers good resistance to thermal shock, rubbing abrasion and corrosion

APPLICATIONS

- Continuous casting rolls
- Valve seats, sealing closures, pipework elements

TYPICAL ALL-WELD METAL ANALYSIS – M12 shielding gas

C	Mn	Si	Cr	Ni	Mo
0.06	1.1	0.8	12.5	4.0	0.5

Structure: martensite + ferrite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES – M12 shielding gas

As welded hardness: 3-layer deposit on CMn steel (S235): 39 - 43 HRc
All-weld metal hardness: 33 - 37 HRc

CONDITIONS OF USE

Current type	Shielding gas	Gas flow rate
DC+ or pulsed	EN ISO 14175: M12, I1, M13, M21	10 - 20 l/min

OPERATING CONDITIONS

Diameter [mm]	Current [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
1.2	100 - 250	220	17 - 32	28	10 - 20	15
1.6	120 - 350	250	17 - 33	28	10 - 20	15
2.0	160 - 400	300	20 - 33	29	15 - 25	20
2.4	200 - 450	350	22 - 33	30	15 - 25	20

Recovery: 98 %

WELDING POSITIONS

EN ISO 6947 PA, PB, PC, (PF, PG, PD).
ASME IX 1G, 1F, 2G, 2F, (3G, 3F, 4F, 4G)

PACKAGING

Diameter	≤ 2.4 mm	≥ 2.4 mm	
Standard packaging	EN ISO 544: BS 300 spool	B 450 coil	Drum
Weight	15 kg	25 kg	Up to 330 kg

Other packaging and other diameters: please consult us