


Technical data sheet <small>011121MBA</small>	Cored welding wire CHROMECORE 414MM-S	 Welding Alloys
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CLASSIFICATION

EN 14700: T Fe7

DESCRIPTION

- Tubular cored wire for submerged arc welding applications
- Hard ferritic-martensitic stainless steel deposit alloyed with Ni and Mo
- The deposit resists corrosion, wear, galling and thermal fatigue
- Specially designed to give the required 414MM-S properties from the first layer

APPLICATIONS

Extensively used as a cladding alloy for rebuilding steel mill rolls subject to repetitive thermal stresses, corrosion and metal-to-metal wear. Typical applications include cladding of continuous casting rolls and certain rolls used in hot rolling applications.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo	Nb	V
0.15	1.2	0.5	12.3	2.2	1.2	0.1	0.2

Structure: martensite + ferrite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness (3-layer deposit): 43 - 47 HRc

FLUX DESCRIPTION

	WA FLUX 325	WA FLUX 385	WA FLUX 415	WA ULTRAFLUX
EN ISO 14174 class	S A AB 1 65	S A AF 2 64	S A FB 1 55	S A FB 1 55

OPERATING CONDITIONS

Diameter [mm]	Current [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
2.4	200 - 450	350	26 - 30	30	25 - 40	30
2.8	250 - 550	400	28 - 32	30	25 - 40	30
3.2	300 - 650	500	28 - 32	32	25 - 40	30

Recovery: 95%

Preheat prior to welding and slow cooling afterwards are advisable. Stress relief after welding may also be necessary.

WELDING POSITIONS

Flat

PACKAGING

Diameter	≥ 2.4 mm	
Standard packaging	B 450 coil	Drum
Weight	25 kg	Up to 330 kg

Other packaging and other diameters: please consult us