

Technical data sheet

011121MBA

Cored welding wire

CHROMECORE 420-G



CLASSIFICATION

EN 14700: T Fe8

DESCRIPTION

- Tubular wire for gas shielded metal arc hardfacing
- 13% chromium martensitic stainless steel deposit
- Attractive combination of corrosion, oxidation, scaling and wear resistance

APPLICATIONS

- CHROMECORE 420-G is used for hardfacing and reclaiming components subject to moderate corrosion and metal-metal wear. The deposited alloy also has excellent gouging and abrasion resistant properties.

Examples

Extensively used as a cladding alloy on many types of steel industry rolling mill rolls such as table rolls, pinch rolls, scale breaker rolls, coiler rolls, leveller rolls and runout table rolls. Other applications include dragline rope sheaves, dragline rope drums, hydraulic plungers, certain types of valve seats, pulp rotors...

TYPICAL ALL-WELD METAL ANALYSIS

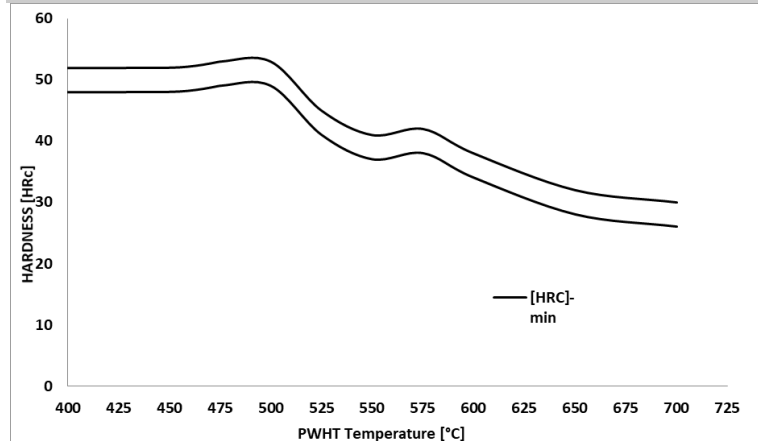
C	Mn	Si	Cr
0.3	0.8	0.6	13

Structure: martensite

HARDNESS (3-LAYER DEPOSIT)

As welded: 48 - 52 HRC

TEMPER CURVE



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

CHROMECORE 420-G, up to Ø 1.6 mm, is suitable as well for downhand as for positional welding by adapting transfer mode and welding parameters as for solid wires.

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

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.