Technical data sheet 011121MBA	Cored welding wire # CHROMECORE 420-S	Welding Alloys

CLASSIFICATION

EN 14700: T Fe8

DESCRIPTION

- Tubular cored wire for submerged arc hardfacing
- 13% chromium martensitic stainless steel deposit
- Resists metal to metal friction
- Attractive combination of corrosion, oxidation and wear resistance

APPLICATIONS

- Cladding of many different types of mill rolls and guides used in the steelmaking industry, valve seats, dragline rope drums and sheaves, railway retarders.

TYPICAL ALL-WELD METAL ANALYSIS [%]

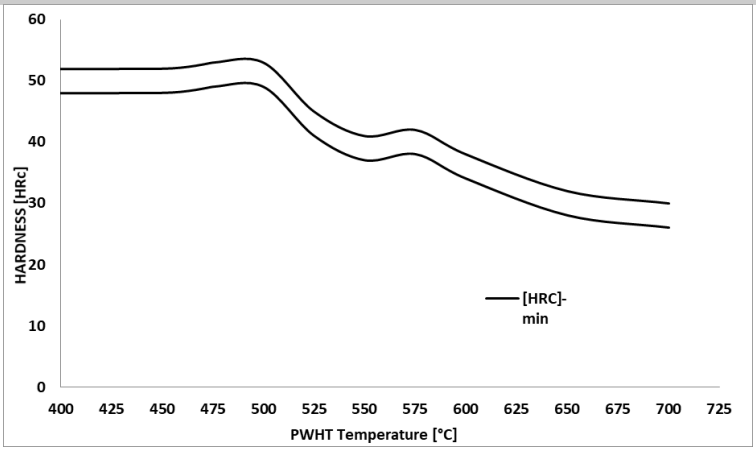
C	Mn	Si	Cr
0.35	1	0.8	13

Structure: martensite

HARDNESS (3-LAYER DEPOSIT)

As welded: 48 - 52 HRc

TEMPER CURVE



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 - 60	30
2.8	250 - 550	400	28 - 32	30	25 - 60	30
3.2	300 - 650	500	28 - 32	30	25 - 60	30

Recovery: 95%
Current type/polarity: DC+ or DC-

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