

Technical data sheet

EN220223BG

Cored welding wire

CHROME CORE 430-G**CLASSIFICATION**

EN 14700: T Fe7

DESCRIPTION

- Tubular wire for gas shielded metal arc hardfacing
- 17% chromium ferritic-martensitic stainless steel deposit

APPLICATIONS

- Used for corrosion and wear resistant surfacing applications
- Good high temperature corrosion resistance, oxidation resistance up to 900°C
- Suitable for use in presence of sulphurous gas
- Sub-layer before hardfacing with 13% chromium martensitic alloys

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr
0.05	0.90	0.70	17.5

Structure: ferrite + martensite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: 3-layer deposit: 220 HB

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