Technical data sheet 011121MBA	Cored welding wire # CHROMECORE 592-S	Welding Alloys

CLASSIFICATION

EN 14700: T ZFe7

DESCRIPTION

- Tubular cored wire for submerged arc hardfacing
- 17% chromium martensitic stainless steel deposit with improved hardness stabilty at high temperature
- Offers good high-temperature corrosion resistance and resists oxidation up to 900°C
- Suitable for use in the presence of sulphurous gas
- Excellent combination of hardness, strength and toughness coupled with temper resistance and resistance to oxidation
- Machinable weld deposit

APPLICATIONS

- Cladding / hardfacing 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
- Hardfacing sealing faces of gas, water and steam valves and fittings made from unalloyed or low-alloy steels
- Welding martensitic or martensitic-ferritic stainless steels when matching properties are required.

TYPICAL ALL-WELD METAL ANALYSIS (with WA ULTRA FLUX)

C	Mn	Si	Cr	Ni	Mo	Nb	V
0.3	0.8	0.5	17	0.7	0.7	0.25	0.25

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-layer deposit as-welded: 42 - 48 HRC
Hardness depends on base material composition, dilution level and preheat temperature.
Preheat at 200 - 400°C is recommended, followed by cooling in quiet air.
Fabrication welds should be annealed at 650 - 750°C.

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%

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