

Technical data sheet

011121MBA

Cored welding wire

CHROMECORE DN-S**CLASSIFICATION**

EN 14700: T Fe7

DESCRIPTION

- Tubular wire for submerged arc cladding of steel mill rolls
- Nitrogen-containing 13% Cr martensitic stainless steel weld deposit optimised for corrosion resistance
- The deposit resists corrosion, wear, galling and thermal fatigue

APPLICATIONS

Extensively used as a cladding alloy for rebuilding steel mill rolls subject to repetitive thermal stresses, corrosion and metal-to-metal wear.

Examples

Continuous casting rolls, hot rolling mills, steam turbine components, valve seats, valve gates, valve wedges, safety valves

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo	Co	V	W	N
0.070	1.15	0.75	13.8	3.0	0.5	2.0	0.55	0.80	0.07

Structure: martensite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: 3-layer deposit as welded: 42 - 46 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 - 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+

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