

Technical data sheet

011121MBA

Cored welding wire

CHROMECORE 434N-O**CLASSIFICATION**

EN 14700: T Fe7

DESCRIPTION

- Self-shielded tubular wire for cladding continuous casting rolls
- Nitrogen-containing 17% Cr martensitic stainless steel weld deposit
- Designed to give a 414N-O weld metal composition in one layer
- The deposit has good high-temperature corrosion and oxidation resistance

APPLICATIONS

CHROMECORE 434N-O is used for cladding and rebuilding mill rolls and surfaces undergoing wear at high temperatures. It is especially suited to the first layer of cladding to give a martensitic nitride 414-type deposit, prior to building up extra layers with CHROMECORE 414N-O.

Examples

Continuous casting rolls, hot-rolling mills, steam turbines, valve seats etc.

TYPICAL ALL-WELD METAL ANALYSIS [%]

| C | Mn | Si | Cr | Ni | Mo | N |
|------|-----|-----|------|-----|-----|-----|
| 0.05 | 1.2 | 0.7 | 17.5 | 3.5 | 0.5 | 0.1 |

Structure: ferrite + martensite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: 3-layer deposit: 35 - 40 HRc

CONDITIONS OF USE

| Current type | Protection |
|--------------|---------------|
| DC+ | Self-shielded |

OPERATING CONDITIONS

| Diameter [mm] | Current [A] | | Voltage [V] | | Stick-out [mm] | |
|---------------|-------------|---------|-------------|---------|----------------|---------|
| | Range | Optimum | Range | Optimum | Range | Optimum |
| 1.6 | 150 - 300 | 250 | 26 - 32 | 28 | 20 - 30 | 25 |
| 2.4 | 250 - 350 | 300 | 25 - 28 | 27 | 25 - 35 | 30 |

Recovery: 90%

WELDING POSITIONS

Flat, half up, half down

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