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| Technical data sheet 030222JMBA | Cored welding wire CORRESIST-O |  Welding Alloys |
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CLASSIFICATION

EN 14700 T Fe12

DESCRIPTION

- Open arc wire for cladding of continuous casting rolls
- Specially designed iron based super alloy for high temperature and corrosion applications

APPLICATIONS

Cladding of vertical upper segment rolls in continuous casting machines

Designed for continuous casting applications for which martensitic alloys are unsuitable

TYPICAL ALL-WELD METAL ANALYSIS (%)

| C | Mn | Si | Cr | Ni | Mo | Others* |
|------|-----|-----|----|----|----|---------|
| 0.04 | 1.4 | 0.7 | 20 | 12 | 4 | + |

Structure: austenite + 3 - 15 % ferrite

- Rare earth elements, nitrogen and carbon stabilizing elements

CONDITIONS OF USE

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

OPERATING CONDITIONS

| Diameter [mm] | Current [A] | | Voltage [V] | | Stick-out [mm] | |
|---------------|-------------|---------|-------------|---------|----------------|---------|
| | Range | Optimum | Range | Optimum | Range | Optimum |
| 2.4 | 200 - 450 | 350 | 26 - 30 | 28 | 25 - 50 | 30 |

Recovery \geq 90%

WELDING POSITIONS

Flat, half up, half down

STANDARD DIAMETER (mm)

2.4

Other diameters: please consult us

PACKAGING

| Diameter | \leq 2.4 mm | \geq 2.4 mm | |
|---------------------------------|--------------------|---------------|--------------|
| Standard packaging (EN ISO 544) | Basket spool BS300 | Coil B450 | Drum |
| Weight | 15 kg | 25 kg | Up to 330 kg |

Other packaging: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.