

Technical data sheet

011121MBA

Cored welding wire

CHROME CORE 4142N-S**CLASSIFICATION**

EN 14700: T Fe7

DESCRIPTION

- Tubular wire for submerged arc cladding steel mill rolls
- 2-layer technique to achieve required 4142N-S composition on new rolls
- The alloy has high hardness and excellent wear and galling resistance
- Ferritic-martensitic stainless steel weld deposit with excellent resistance to thermal fatigue

APPLICATIONS

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

Typical applications include cladding of continuous caster rolls and certain rolls used in hot rolling applications, steam turbine components, valve seats, valve gates, valve wedges, safety valves etc.

TYPICAL ALL-WELD METAL ANALYSIS

Structure: martensite + ferrite

This alloy is specially designed to achieve required 414N-S composition in 2 layers on unclad new rolls

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 2-layer deposit, as welded: 40 - 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	400	26 - 32	30	25 - 50	30
3.2	300 - 650	450	28 - 32	30	25 - 50	30

Current type/polarity: DC+ or 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