

Technical data sheet

011121MBA

Cored welding wire

CHROMECORE 414DN-O



CLASSIFICATION

EN 14700: T ZFe7

DESCRIPTION

- Self-shielded tubular wire for cladding continuous casting rolls
- 13% Cr martensitic stainless steel weld deposit, with addition of Co, V, W and Mo
- The deposit resists corrosion, stress corrosion, erosion, wear, galling, thermal shocks and thermal fatigue

APPLICATIONS

CHROMECORE 414DN-O is the product of choice for cladding and rebuilding mill rolls undergoing the working conditions described above.

Examples:

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

TYPICAL ALL-WELD METAL ANALYSIS

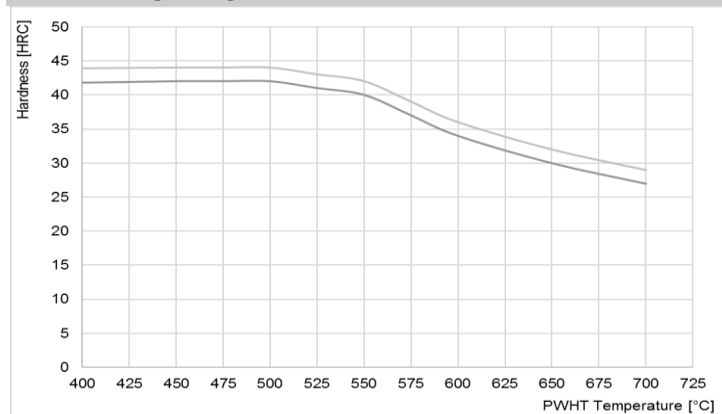
C	Mn	Si	Cr	Ni	Mo	W	V	Co	N
0.05	1.5	0.9	13.6	5	0.5	0.8	0.5	2	0.10

Structure: martensite

HARDNESS (3-LAYER DEPOSIT)

As welded: 40 - 45 HRc

TEMPER CURVES



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
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

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.