


Technical data sheet <small>011121MBA</small>	Cored welding wire CHROMECORE 410-G	 Welding Alloys
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CLASSIFICATION

EN 14700: T Fe7

DESCRIPTION

- Metal-cored tubular wire for gas-shielded metal arc hardfacing
- 13% chromium martensitic stainless steel deposit
- The deposit offers good resistance to thermal shock, rubbing abrasion and corrosion

APPLICATIONS

- Continuous casting rolls
- Valve seats, sealing closures, steam turbine components, pipework elements

TYPICAL ALL-WELD METAL ANALYSIS

C	Si	Mn	Cr
0.07	0.2	0.6	13

Structure: martensite + ferrite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: 3-layer deposit (as welded): 39 - 45 HRC

CONDITIONS OF USE

Current type	Shielding gas	Gas flow rate
DC+ or pulsed	EN ISO 14175: M12, I1, M13, M21	10 - 20 l/min

Minimum recommended preheat and interpass temperature: 200°C

OPERATING CONDITIONS

Diameter [mm]	Current [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
1.2	100 - 250	220	17 - 32	28	10 - 20	15
1.6	120 - 350	250	17 - 33	28	10 - 20	15

Recovery: 98 %

WELDING POSITIONS

EN ISO 6947: PA, PB, PC, (PF, PG, PD).

ASME IX: 1G, 1F, 2G, 2F, (3G, 3F, 4F, 4G)

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.