


Technical data sheet <small>011121MBA</small>	Cored welding wire CHROMECORE 4115-G	
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CLASSIFICATION

EN 14700: T ZFe7
EN ISO 17633-A: T Z 17Mo M M12 1
Material number: 1.4115

DESCRIPTION

- Tubular wire for gas shielded metal arc welding
- 17% chromium martensitic stainless steel deposit
- Combines hardness, strength and toughness coupled with temper resistance and resistance to oxidation
- Scaling resistant up to 900°C
- Machinable weld deposit

APPLICATIONS

- Hardfacing on sealing faces of gas, water and steam valves and fittings made from unalloyed or low-alloy steels, for service temperatures up to 450°C.
- Hardfacing of steel mill rollers.
- Welding martensitic or martensitic-ferritic stainless steels when matching properties are required.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Mo	Ni
0.20	0.70	0.70	17.0	1.1	0.2

Structure: martensite - ferrite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: 3-layer deposit, as welded: 36 - 45 HRc

Hardness depends on base material composition, dilution level, shielding gas type and preheat temperature.

Preheat at 200 - 400°C is recommended, followed by cooling in quiet air. Fabrication welds should be annealed at 650 - 750°C.

CONDITIONS OF USE

Current type	Shielding gas
DC+ Pulsed current is recommended for fabrication welding.	EN ISO 14175
	M11: Ar + 0.5 - 5 % CO ₂
	M13: Ar + 0.5 - 3% O ₂
	M21: Ar + 15 - 25 % CO ₂

OPERATING CONDITIONS

Diameter [mm]	Current [A]		Tension [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

CHROMECORE 4115-G is suitable as well for flat as for positional welding by adapting transfer mode and welding parameters as for solid wires.

PACKAGING

Diameter	1.2 mm	1.6 mm
Spool type	EN ISO 544: BS300	
Weight	15 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.