


<b>Technical data sheet</b>  <small>011121MBA</small>	<b>Cored welding wire</b>  <b>CHROME CORE 414-G</b>	 <b>Welding Alloys</b>
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### CLASSIFICATION

EN 14700: T Fe7

### DESCRIPTION

- Metal-cored tubular wire for gas-shielded metal arc hardfacing
- Martensitic stainless steel deposit
- Deposit offers good resistance to thermal shock, rubbing abrasion and corrosion

### APPLICATIONS

- Continuous casting rolls
- Valve seats, sealing closures, pipework elements

### TYPICAL ALL-WELD METAL ANALYSIS – M12 shielding gas

C	Mn	Si	Cr	Ni	Mo
0.06	1.1	0.8	12.5	4.0	0.5

Structure: martensite + ferrite

### TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES – M12 shielding gas

As welded hardness: 3-layer deposit on CMn steel (S235): 39 - 43 HRc

All-weld metal hardness: 33 - 37 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

### 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
2.0	160 - 400	300	20 - 33	29	15 - 25	20
2.4	200 - 450	350	22 - 33	30	15 - 25	20

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.