

Technical data sheet

011121MBA

Cored welding wire

CHROME CORE 4142N-O**CLASSIFICATION**

EN 14700: T Fe7

DESCRIPTION

- Self-shielded tubular wire for cladding of steel mill rolls
- Specially designed to achieve the 4142N composition in two layers on new rolls
- The second layer has a martensitic structure that resists corrosion, stress corrosion, erosion, wear, galling, thermal shocks and thermal fatigue

APPLICATIONS

CHROME CORE 4142N-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	N
0.04	1.4	1.2	16.0	5.0	0.8	0.1

TYPICAL WELD METAL CHARACTERISTICS (2-layer cladding on W-Nr. 1.8070 (21CrMoV5-11))

C	Mn	Si	Cr	Ni	Mo	N
0.08	1.0	0.7	13	3.8	0.6	0.08

*Actual weld metal composition of the deposit could change depending on the base metal carbon specification and the level of dilution

Typical microstructure: martensite + 5 % delta ferrite

Hardness: 40 - 45 HRc

CONDITIONS OF USE

Current type	Shielding
DC+	Self-shielded

OPERATING CONDITIONS

Diameter (mm)	Current (A)		Voltage (V)		Stick-out (mm)	
	Range	Optimum	Range	Optimum	Range	Optimum
1.6	150 - 300	250	26 - 32	28	20 - 30	25
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