

Technical data sheet <small>011121MBA</small>	Cored welding wire CHROMECORE 414 COILER-S	 Welding Alloys
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CLASSIFICATION

EN 14700: T Fe8

DESCRIPTION

- Tubular cored wire for submerged arc cladding applications
- Controlled-carbon martensitic stainless steel deposit alloyed with nickel, molybdenum and tungsten
- The deposit is exceptionally hard and resists corrosion and wear at high temperatures
- Resists galling and thermal fatigue

APPLICATIONS

- Hardfacing of continuous casting rolls and rolls used in hot rolling applications.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo	W	V	Nb
0.25	1.1	0.6	12	1.4	0.6	0.35	0.07	0.05

Structure: martensite + ferrite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness (3-layer deposit): 50 - 55 HRc

FLUX DESCRIPTION

	WA FLUX 325	WA FLUX 385	WA FLUX 415	WA ULTRAFLUX
EN ISO 14174 class	S A AB 1 65	S A AF 2 64	S A FB 1 55	S A FB 1 55

OPERATING CONDITIONS

Diameter [mm]	Current [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
2.4	200 - 450	350	26 - 30	30	25 - 60	30
2.8	250 - 550	400	28 - 32	30	25 - 60	30
3.2	300 - 650	500	28 - 32	30	25 - 60	30

Recovery: 95%

Current type/polarity: DC+

Preheating to 250 - 300°C, and slow cooling after cladding, are generally necessary. Depending on the type of base material used, under-layers of products such as HARDFACE BUF-S and CHROMECORE 430-S are applied to obtain a homogeneous, crack-free deposit.

WELDING POSITIONS

Flat

PACKAGING

Diameter	≥ 2.4 mm	
Standard packaging	B 450 coil	Drum
Weight	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.