

Technical data sheet

011121MBA

Cored welding wire

CHROME CORE 414DN-S**CLASSIFICATION**

EN 14700: T ZFe7

DESCRIPTION

- Tubular wire for submerged arc cladding of steel mill rolls
- Nitrogen-containing 13% Cr martensitic stainless steel weld deposit optimised for corrosion resistance
- The deposit resists corrosion, wear, galling and thermal fatigue

APPLICATIONS

Extensively used as a cladding alloy for rebuilding steel mill rolls subject to repetitive thermal stresses, corrosion and metal-to-metal wear.

Examples

Continuous casting rolls, hot rolling mills, steam turbine components, valve seats, valve gates, valve wedges, safety valves

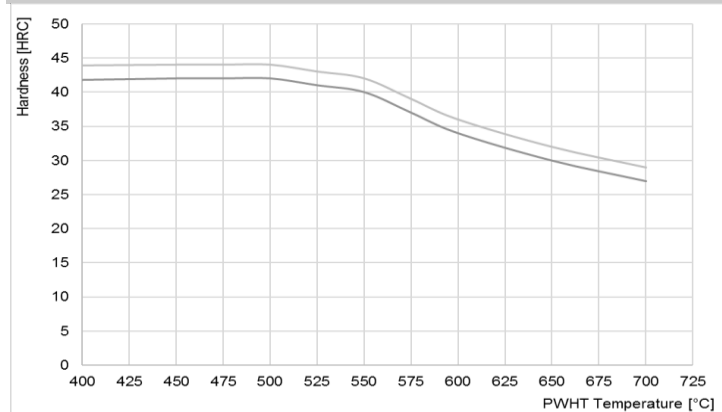
TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo	Co	V	W	N
0.05	1.2	0.6	14.0	4.0	0.5	1.8	0.55	0.8	0.10

Structure: martensite

HARDNESS (3-LAYER DEPOSIT)

As welded: 40 - 45 HRc

TEMPER CURVES**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+ or DC-

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.