

**Technical data sheet**

011121MBA

Cored welding wire

**CHROMECORE 414NX-O****CLASSIFICATION**

EN 14700: T ZFe7

**DESCRIPTION**

- Self-shielded tubular wire for cladding of steel mill rolls
- Deposits a controlled carbon, nitrogen-alloyed 414 Cr martensitic stainless steel
- Wire deposit is strengthened with niobium, vanadium and rare earth materials for temper, oxidation, corrosion and creep 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	Nb	V	N	REM
0.08	1.2	0.3	14.0	3.5	1.5	0.2	0.2	0.08	++

Typical microstructure: martensite + 5 % delta ferrite

**TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES**

Typical hardness: 3-layer deposit, as welded: 42 – 48 HRc

**CONDITIONS OF USE**

Current type	Protection
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