

Technical data sheet

011121MBA

Cored welding wire

CHROMECORE 420-O



CLASSIFICATION

EN 14700: T Fe8

DESCRIPTION

- Tubular wire for self-shielded metal arc hardfacing
- 13% chromium martensitic stainless steel deposit
- Attractive combination of corrosion, oxidation, scaling and wear resistance

APPLICATIONS

- CHROMECORE 420-O is used for hardfacing and reclaiming components subject to moderate corrosion and metal-metal wear. The deposited alloy also has excellent gouging and abrasion resistant properties.

Examples

Extensively used as a cladding alloy on many types of steel industry rolling mill rolls such as table rolls, pinch rolls, scale breaker rolls, coiler rolls, leveler rolls and runout table rolls. Other applications include dragline rope sheaves, dragline rope drums, hydraulic plungers, certain types of valve seats, pulp rotors...

TYPICAL ALL-WELD METAL ANALYSIS [%]

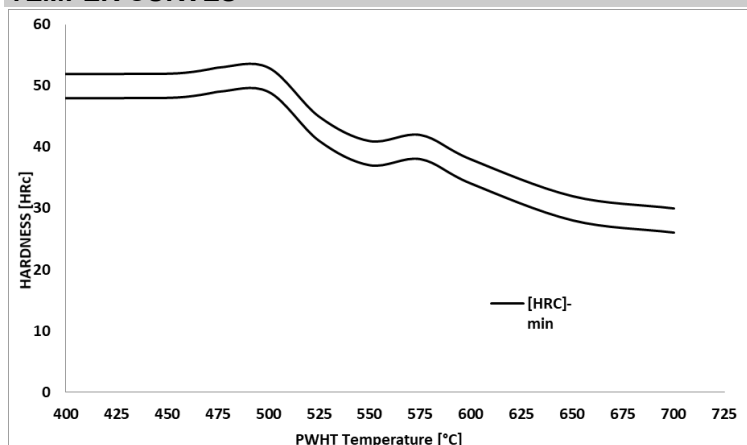
C	Mn	Si	Cr
0.3	0.8	0.6	13

Structure: martensite

HARDNESS (3-LAYER DEPOSIT)

As welded: 48 - 52 HRC

TEMPER CURVES



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 - 350	270	24 - 35	28	25 - 50	25
2.0	250 - 400	300	26 - 35	28	25 - 50	35
2.4	250 - 450	350	26 - 35	28	25 - 50	40
2.8	250 - 450	400	28 - 35	30	25 - 50	40

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

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.