

Technical data sheet

011121MBA

Cored welding wire

CHROME CORE 420-S



CLASSIFICATION

EN 14700: T Fe8

DESCRIPTION

- Tubular cored wire for submerged arc hardfacing
- 13% chromium martensitic stainless steel deposit
- Resists metal to metal friction
- Attractive combination of corrosion, oxidation and wear resistance

APPLICATIONS

- Cladding of many different types of mill rolls and guides used in the steelmaking industry, valve seats, dragline rope drums and sheaves, railway retarders.

TYPICAL ALL-WELD METAL ANALYSIS [%]

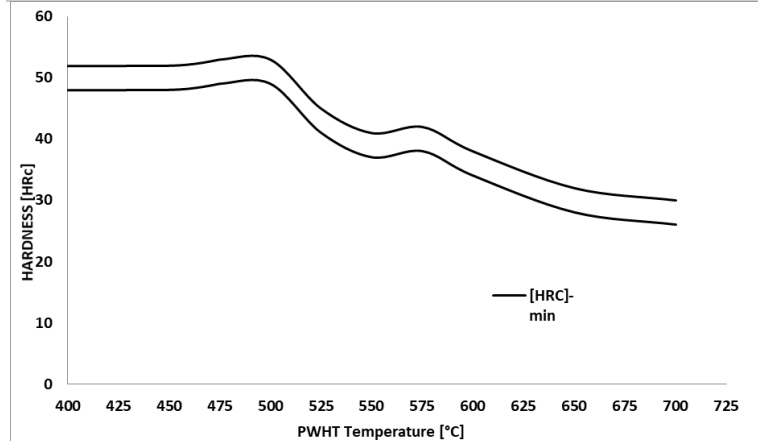
C	Mn	Si	Cr
0.35	1	0.8	13

Structure: martensite

HARDNESS (3-LAYER DEPOSIT)

As welded: 48 - 52 HRC

TEMPER CURVE



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.