


Technical data sheet <small>011121MBA</small>	Cored welding wire CHROMECORE 423Cr-S	
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CLASSIFICATION

EN 14700: T Fe7

DESCRIPTION

- Tubular wire for submerged arc cladding steel mill rolls
- The alloy has high hardness and excellent wear and galling resistance
- Ferritic-martensitic stainless steel weld deposit with excellent resistance to thermal fatigue

APPLICATIONS

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

Typical applications include cladding of continuous caster rolls and certain rolls used in hot rolling applications.

Preheat prior to welding and slow cooling after welding is often essential with this alloy. In some instances, stress relieving of the components is advisable.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo	Nb	V
0.12	1.1	0.5	12.5	2.7	1.3	0.12	0.15

Structure: martensite + ferrite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: 3-layer deposit, as welded: 42 - 46 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 - 40	30
3.2	300 - 650	500	28 - 32	32	25 - 40	30

Recovery: 95%

Preheat prior to welding and slow cooling afterwards are advisable. Stress relief after welding may also be necessary.

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.