

Technical data sheet

011121MBA

Cored welding wire

CHROME CORE 430-O**CLASSIFICATION**

EN 14700: T Fe7

DESCRIPTION

- Tubular wire for self-shielded metal arc hardfacing
- 17% chromium ferritic-martensitic stainless steel deposit

APPLICATIONS

- Used for corrosion and wear resistant surfacing applications
- Good high temperature corrosion resistance, oxidation resistance up to 900°C
- Suitable for use in presence of sulphurous gas
- Sub-layer before hardfacing with 13% chromium martensitic alloys

TYPICAL ALL-WELD METAL ANALYSIS [%]

C	Mn	Si	Cr
0.05	0.9	0.7	17.5

Structure: ferrite + martensite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-layer deposit: 220 HB

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