

<b>Technical data sheet</b>  <small>011121MBA</small>	<b>Cored welding wire</b>  <b>CHROMECORE 430-S</b>	
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### CLASSIFICATION

EN 14700: T Fe7

### DESCRIPTION

- Tubular cored wire for submerged arc hardfacing
- 17% chromium ferritic stainless steel deposit
- Offers good high-temperature corrosion resistance, and resists oxidation up to 900°C
- Resists attack by sea water and organic acids.
- Suitable for use in the presence of sulphurous gas

### APPLICATIONS

- Cladding of continuous casting rolls, valve seats, axles, pump bodies and rotors
- Useful as an under-layer before hardfacing with chromium martensitic steels

### 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 as welded: 220 HB

### 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+

### 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