

Technical data sheet

011121MBA

Cored welding wire

CHROMECORE 430N-S**CLASSIFICATION**

EN 14700: T Fe7

DESCRIPTION

- Tubular wire for submerged arc hardfacing
- Nitrogen-containing martensitic stainless steel weld deposit
- Designed to give a 414N-S weld metal composition in one layer
- The deposit has good high-temperature corrosion and oxidation resistance

APPLICATIONS

CHROMECORE 430N-S is used for cladding and rebuilding mill rolls and surfaces undergoing wear at high temperatures. It is especially suited to the first layer of cladding to give a martensitic nitrided 414-type deposit, prior to building up extra layers with CHROMECORE 414N-S.

Examples:

Continuous casting rolls, hot-rolling mills, steam turbines, valve seats etc.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo	N
0.07	1.1	0.7	17.5	3.4	0.5	0.05

Structure: martensite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3 layer deposit as welded: 35-40 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 - 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

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.