


<b>Technical data sheet</b>  <small>011121MBA</small>	<b>Cored welding wire</b>  <b>CHROME CORE 434DN-S</b>	
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### CLASSIFICATION

EN 14700: T Fe7

### DESCRIPTION

- Tubular wire for submerged arc cladding of steel mill rolls
- Nitrogen-containing 17% Cr martensitic stainless steel weld deposit optimised for corrosion resistance
- The deposit resists corrosion, wear, galling and thermal fatigue

### APPLICATIONS

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

#### Examples

Continuous casting rolls, hot rolling mills, steam turbine components, valve seats, valve gates, valve wedges

### TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo	Co	V	W	N
0.07	1.2	0.8	17	3.5	0.5	2	0.5	0.8	0.08

Structure: martensite + ferrite

### TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: 3-layer deposit as welded: 38 - 42 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