

**Technical data sheet**

011121MBA

Cored welding wire

**CHROMECORE 434N-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 434N-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 nitrogen enhanced 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
0.04	1.2	0.7	17.5	3.5	0.5	0.08

Structure: martensite

**TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES**

Hardness: 3-layer deposit as welded: 30-38 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