

# CHROME CORE 410-G

## CLASSIFICATION

EN 14700 T Fe7

## DESCRIPTION

- Tubular wire for gas shielded metal arc hardfacing
- 13% chromium martensitic stainless steel deposit
- Deposit resists corrosion, erosion and abrasive wear

## APPLICATION

Used for hardfacing continuous casting rolls, steam turbine components, centrifugal pump impellers, valve seats, valve gates, valve wedges, safety valves etc.

## TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Fe
0.08	0.50	0.30	13.0	Rest

Structure: martensite + ferrite

## TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-Layer deposit:

As welded: 40 - 43 HRc

## CONDITIONS OF USE

Current type	Shielding gas
DC (+)	M12 / M13 / M20 / M21

## OPERATING CONDITIONS

Diameter [mm]	Amperage [A]	Voltage [V]	Stick-out [mm]	Gas flow [l/min]
1.2	100 - 300	24 - 32	12 - 25	10 - 20
1.6	150 - 300	24 - 32	12 - 25	10 - 20
2.0	200 - 400	24 - 32	12 - 30	10 - 20
2.4	250 - 450	24 - 32	12 - 30	10 - 20

Recovery: > 95 %

### WELDING POSITIONS

Chromecore 410-G, up to Ø 1.6 mm, is suitable as well for downhand as for positional welding by adapting transfer mode and welding parameters as for solid

### STANDARD DIAMETERS (mm)

1.2, 1.6, 2.0, 2.4

Other diameters: please consult us

### PACKAGING

Diameter	2.4 mm	2.4 mm	2.4 mm
Standard packaging [EN ISO 544]	Spool : BS 300	Coil : B 450	Drum
Weight	15 kg	25 kg	Up to 330 kg