

# CHROME CORE 410-S

## CLASSIFICATION

EN 14700 T Fe7

## DESCRIPTION

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

## APPLICATIONS

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 - 44 HRC

## CONDITIONS OF USE

### Current type

### Shielding

DC (+)

WAF 325 or WAF 385

### FLUX DESCRIPTION

WAF 325

WAF 385

Classification

EN 760: S A FB 1 65 DC H5

EN 760: S A AB 2 65 DC H5

Redrying

2 hours at 250°C ± 50°C

Packaging

bags (25 kg)

## OPERATING CONDITIONS

Diameter [mm]	Amperage [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
1.6	150 - 300	250	26 - 32	30	15 - 30	25
2.0	200 - 350	280	26 - 32	30	20 - 50	25

Diameter [mm]	Amperage [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
2.4	200 - 450	350	26 - 32	30	25 - 50	30
2.8	250 - 550	400	28 - 32	30	25 - 50	30
3.2	300 - 650	500	28 - 32	30	25 - 50	30

Recovery: 95 %

#### WELDING POSITIONS

Flat

#### STANDARD DIAMETERS (mm)

1.6, 2.0, 2.4, 2.8, 3.2

Other diameters: please consult us

#### PACKAGING

Diameter	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