

# CHROME CORE 414-G

## CLASSIFICATION

EN 14700 T Fe7

## DESCRIPTION

- Tubular wire for gas shielded metal arc hardfacing
- 13% chromium martensitic stainless steel deposit alloyed with Ni and Mo

## APPLICATIONS

Hardfacing parts undergoing corrosion, oxidation, scaling and wear resistance

### Examples

Steel mill rolls, pumps, hydraulic turbines, compressors etc.

## TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo	Fe
0.04	0.80	0.60	13.0	4.10	0.50	Rest

Structure: martensite

## TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-Layer deposit:

As welded: 38 - 42 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 414-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
Standard packaging [EN ISO 544]	Spool : BS 300	Coil : B 450	Drum
Weight	15 kg	25 kg	Up to 330 kg