

CHROME CORE 414-O

CLASSIFICATION

EN 14700 T Fe7

DESCRIPTION

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

APPLICATIONS

Hardfacing parts undergoing corrosion, oxidation, scaling and wear resistance

Examples

Continuous casting rolls, valve seats, valve gates, valve wedges, safety valves 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 + ferrite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-Layer deposit: as welded 38 - 42 HRc

CONDITIONS OF USE

Current type	Shielding
DC (+)	Self shielded

OPERATING CONDITIONS

Diameter [mm]	Amperage [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
1.6	150 - 300	270	24 - 35	28	15 - 25	25
2.0	200 - 400	300	26 - 35	28	20 - 50	30
2.4	250 - 450	350	26 - 35	28	25 - 50	30

Diameter [mm]	Amperage [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
2.8	250 - 450	400	28 - 35	30	25 - 50	40

Recovery: 90%

WELDING POSITIONS

Flat, half up, half down

STANDARD DIAMETERS (mm)

1.2, 1.6, 2.0, 2.4, 2.8

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