

# CHROME CORE 4142MM-S

## CLASSIFICATION

EN 14700 T Fe7

## DESCRIPTION

- Tubular wire for submerged arc cladding steel mill rolls
- 2 layers technique to achieve required 414MM-S composition on new rolls
- The alloy has high hardness and excellent wear and galling resistance
- Ferritic-martensitic stainless steel weld deposit with excellent resistance to thermal fatigue

## APPLICATIONS

Extensively used as a cladding alloy for rebuilding various steel mill rolls subject to repetitive thermal stress, corrosion and metal-to-metal wear. Typical applications include cladding of continuous caster rolls and certain rolls used in hot rolling applications.

Preheat prior to welding and slow cooling after welding is often essential with this alloy. In some instances, stress relieving of the components is advisable.

## TYPICAL ALL-WELD METAL ANALYSIS

Structure: martensite + ferrite

This alloy is specially designed to achieve required 414MM-S composition in 2 layers on new rolls

## TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 2 layers deposit: as welded 40 - 46 HRc

## CONDITIONS OF USE

### Current type

DC (+)

### Shielding

WAF 325

## FLUX DESCRIPTION

WAF 325

Classification

EN 760: S A AB 1 65 DC H5

Redrying

2 hours at 250°C ± 50°C

Packaging

bags (25 kg)

## OPERATING CONDITIONS

Diameter

Amperage [A]

Voltage [V]

Stick-out [mm]

[mm]

Range

Optimum

Range

Optimum

Range

Optimum

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	450	28 - 32	30	25 - 50	30

Recovery: >95%

#### WELDING POSITIONS

Flat

#### STANDARD DIAMETERS (mm)

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