CHROMECORE 414MM-S

CLASSIFICATION

EN 14700 T Fe7

DESCRIPTION

• Tubular wire for submerged arc cladding steel mill 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 stresses, 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

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3 layer deposit as welded: 42 – 48 HRc

CONDITIONS OF USE

Current type	Shielding
DC (+)	WAF 325 or WAF 385

FLUX DESCRIPTION	WAF 325	WAF 385
Classification	EN 760: S A AB 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	Amperage [A]		Voltage [V]		Stick-out [mm]	
[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	Amperage [A]		Voltage [V]		Stick-out [mm]	
[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)

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