

CHROME CORE 414N-O

CLASSIFICATION

EN 14700 T Fe7

DESCRIPTION

- Nitrogen bearing open arc wire for cladding of continuous casting rolls
- Nitrogen-containing 13% Cr martensitic stainless steel weld deposit optimised for corrosion resistance
- The alloy has high hardness and excellent wear and galling resistance
- Ferritic-martensitic stainless steel weld deposit with excellent resistance to thermal fatigue

APPLICATIONS

The fully martensitic microstructure provides outstanding tempering resistance, wear resistance, excellent response to thermal fatigue and stress corrosion cracking.

Extensively used as a cladding alloy for rebuilding various steel mill rolls subject to repetitive thermal stress, corrosion and metal-to-metal wear.

Examples

Typical applications include cladding of continuous caster rolls and certain rolls used in hot rolling applications, steam turbine components, valve seats, valve gates, valve wedges, safety valves etc..

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-Layer deposit: as welded 40 - 45 HRc

CONDITIONS OF USE

Current type

DC (+)

Self shielded

Shielding

OPERATING CONDITIONS

| Diameter [mm] | Amperage [A] | | Voltage [V] | | Stick-out [mm] | |
|------------------|--------------|---------|-------------|---------|----------------|---------|
| | Range | Optimum | Range | Optimum | Range | Optimum |
| 2.4 | 300 - 400 | 350 | 26 - 28 | 27 | 25 - 40 | 30 |

Recovery: 90%

WELDING POSITIONS

Flat, half up, half down

STANDARD DIAMETERS (mm)

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 |