CHROMECORE 414N-S

CLASSIFICATION

EN 14700 T Fe7

DESCRIPTION

• Tubular wire for submerged arc cladding steel mill 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

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, steam turbine components, valve seats, valve gates, valve wedges, safety valves etc..

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3 layers deposit: as welded 42 - 46 HRc

CONDITIONS OF USE

Current type	Shielding
DC (+)	WAF 325

OPERATING CONDITIONS

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	500	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