

CHROME CORE 414Pinch-S

CLASSIFICATION

EN 14700 T Fe7

DESCRIPTION

- Tubular wire for submerged arc cladding steel mill rolls
- Weld deposit gives high hardness and wear resistance at elevated temperature with excellent thermal fatigue resistance

APPLICATIONS

- Chromecore 414Pinch-S has been developed specifically for depositing onto steel mill pinch rolls, a weld metal that increases in hardness combined with maximum resistance to wear by corrosion, fire cracking and pick up.
- Chromecore 414Pinch-S is most suitable for hardfacing of lower and upper Pinch rolls in hot strip mills.

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Typical hardness after heat treatment: 50 - 54 HRc

CONDITIONS OF USE

Current type

DC (+) or DC (-)

Shielding

WAF 325

FLUX DESCRIPTION

WAF 325

Classification	EN 760: S A FB 1 65 DC H5
Basicity index	2.3 (according to Boniszewski)
Granulometry	0.25 - 2.5 mm
Current	DC by preference
Redrying	2 hours at 300°C - 350°C
Packaging	bags (25 kg) or metallic drums (200 kg)

OPERATING CONDITIONS

Diameter [mm]	Amperage [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
2.4	200 - 450	350	28 - 32	30	25 - 50	30
2.8	250 - 500	400	28 - 32	30	25 - 50	30

Diameter [mm]	Amperage [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
3.2	300 - 600	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