

# CHROME CORE 414Wrapper-S

## CLASSIFICATION

EN 14700 T Fe7

## DESCRIPTION

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

## APPLICATIONS

- Chromecore 414Wrapper-S has been developed specifically for hardfacing or refurbishing of Wrapper rolls in hot strip mills, a weld metal that increases in hardness combined with maximum resistance to wear by corrosion, fire cracking and pick up.
- Chromecore 414Wrapper-S is most suitable for hardfacing of Wrapper 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

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