

CHROMECORE 420-G

CLASSIFICATION

EN 14700 T Fe8

DESCRIPTION

- Tubular wire for gas shielded metal arc hardfacing
- 13% chromium martensitic stainless steel deposit
- Attractive combination of corrosion, oxidation, scaling and wear resistance

APPLICATIONS

Chromecore 420-G is used for hardfacing and reclaiming components subject to moderate corrosion and metal-metal wear. The deposited alloy also has excellent gouging and abrasion resistant properties.

Examples

Extensively used as a cladding alloy on many types of steel industry rolling mill rolls such as table rolls, pinch rolls, scale breaker rolls, coiler rolls, leveller rolls and runout table rolls. Other applications include dragline rope sheaves, dragline rope drums, hydraulic plungers, certain types of valve seats, pulp rotors..

TYPICAL ALL-WELD METAL ANALYSIS

| C | Mn | Si | Cr | Fe |
|------|------|------|------|------|
| 0.30 | 1.00 | 1.00 | 13.0 | Rest |

Structure: martensite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-Layer deposit:

As welded 50 HRc

CONDITIONS OF USE

| Current type | Shielding gas |
|--------------|-----------------------|
| DC (+) | M12 / M13 / M20 / M21 |

OPERATING CONDITIONS

| Diameter [mm] | Amperage [A] | Voltage [V] | Stick-out [mm] | Gas flow [l/min] |
|---------------|--------------|-------------|----------------|------------------|
| 1.2 | 100 - 300 | 24 - 32 | 12 - 25 | 10 - 20 |

| Diameter [mm] | Amperage [A] | Voltage [V] | Stick-out [mm] | Gas flow [l/min] |
|---------------|--------------|-------------|----------------|------------------|
| 1.6 | 150 - 300 | 24 - 32 | 12 - 25 | 10 - 20 |
| 2.0 | 200 - 400 | 24 - 32 | 12 - 30 | 10 - 20 |
| 2.4 | 250 - 450 | 24 - 32 | 12 - 30 | 10 - 20 |

Recovery: > 95 %

WELDING POSITIONS

Chromecore 420-G, up to Ø 1.6 mm, is suitable as well for downhand as for positional welding by adapting transfer mode and welding parameters as for solid wires.

STANDARD DIAMETERS (mm)

1.2, 1.6, 2.0, 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 |