

# CHROME CORE 420-O

## CLASSIFICATION

EN 14700 T Fe8

## DESCRIPTION

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

## APPLICATIONS

Chromecore 420-O 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
DC (+)	Self shielded

## OPERATING CONDITIONS

Diameter [mm]	Amperage [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
1.6	150 - 300	270	24 - 35	28	15 - 25	25

Diameter [mm]	Amperage [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
2.0	200 - 400	300	26 - 35	28	20 - 50	30
2.4	250 - 450	350	26 - 35	28	25 - 50	30
2.8	250 - 450	400	28 - 35	30	25 - 50	40

Recovery: 90%

#### WELDING POSITIONS

Flat, half up, half down

#### STANDARD DIAMETERS (mm)

1.2, 1.6, 2.0, 2.4, 2.8

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