CHROMECORE 420-S

CLASSIFICATION

EN 14700 T Fe8

DESCRIPTION

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

APPLICATIONS

Chromecore 420-S 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: 50 HRc

CONDITIONS OF USE

Current type	Shielding
DC (+)	WAF 325 or WAF 385

FLUX DESCRIPTION	WAF 325	WAF 385
Classification	EN 760: S A FB 1 65 DC H5	EN 760: S A AB 2 65 DC H5
Redrying	2 hours at 250°C ± 50°C	
Packaging	bags (25 kg)	

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