CHROMECORE 430-O

CLASSIFICATION

EN 14700 T Fe7

DESCRIPTION

• Tubular wire for self-shielded metal arc cladding of steel mill rolls

• Designed to produce a weld metal chemistry in one layer similar to 414-S all weld metal chemical composition

APPLICATIONS

• Used for corrosion and wear resistant surfacing applications

• Good high temperature corrosion resistance, oxidation resistance up to 900°C

• Suitable for use in presence of sulphurous gas

• Sub-layer before hardfacing with 13 % chromium martensitic alloys

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Fe
0.06	1.00	0.60	17.50	Rest

Structure: ferrite + martensite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-Layer deposit:

As welded 220 HB

CONDITIONS OF USE

Current type	Shielding
DC (+)	Self shielded

OPERATING CONDITIONS

Diameter	Amperage [A]		Voltage [V]		Stick-out [mm]	
[mm]	Range	Optimum	Range	Optimum	Range	Optimum
1.6	150 - 300	270	24 - 35	28	15 - 25	25
2.0	200 - 400	300	26 - 35	28	20 - 50	30

Diameter	Amperage [A]		Voltage [V]		Stick-out [mm]	
[mm]	Range	Optimum	Range	Optimum	Range	Optimum
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)

1.6, 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