

# CHROME CORE 430-S

## CLASSIFICATION

EN 14700 T Fe7

## DESCRIPTION

- Tubular wire for gas 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	17.5	Rest

Structure: ferrite + martensite

## TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-Layer deposit:

As welded: 220 HB

## CONDITIONS OF USE

### Current type

### Shielding gas

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]
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[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	2.4 mm
Standard packaging [EN ISO 544]	Spool : BS 300	Coil : B 450	Drum
Weight	15 kg	25 kg	Up to 330 kg