

CHROME CORE 430-G

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 (+)	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
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 430-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