CHROMECORE 430N-S

CLASSIFICATION

EN 14700 T Fe7

DESCRIPTION

• Nitrogen bearing tubular wire for submerged arc cladding steel mill rolls

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

APPLICATIONS

Enhanced wire chemistry is obtained by over-alloying the consumable according to typical dilution levels observed in open arc welding.

Chromecore 430N-S is suitable as a buffer material onto previously unclad rolls prior to the application of Chromecore 414N-S.

Chromecore 430N-S is intended to replace Chromecore 430-S since it provides a uniform microstructure and properties from the fusion line to the top machined surface.

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3 Layers deposit: as welded 38 - 40 HRc

CONDITIONS OF USE

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

FLUX DESCRIPTION	WAF 325	WAF 385
Classification	EN 760: S A AB 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	Spool EN759 : BS 300	Coil	Drum
Weight	15 kg	25 kg	Up to 330 kg