

# CHROME CORE R 17 4 PH-S

## CLASSIFICATION

EN 14700 T ZFe7

## DESCRIPTION

- Stainless steel tubular wire for submerged arc cladding
- Martensitic precipitation hardening stainless steel deposit
- In the as welded condition, the deposit can be machined to the exact profile required
- It withstands cavitation and corrosion very well
- Heat treatment at 430 - 470°C is recommended after welding and machining in order to achieve a tempered martensitic structure containing Ni/Cu precipitates

## APPLICATIONS

Chromecore R 17 4 PH S is used for cladding or hardfacing steel mill rolls, rebuilding hydro turbine components, shafts, impellers, steam turbine components etc.

## TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Post weld heat treated: 44 - 48 HRc

## CONDITIONS OF USE

### Current type

DC (+) or DC (-)

### Shielding

WAF 325

### FLUX DESCRIPTION

WAF 325

Classification

EN 760: S A AB 1 65 DC H5

Redrying

2 hours at 250°C ± 50°C

Packaging

bags (25 kg)

## OPERATING CONDITIONS

Diameter [mm]	Amperage [A]		Voltage [V]		Stick-out [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**

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