

CORRESIST-S

CLASSIFICATION

EN 14700 T Fe12

DESCRIPTION

- Tubular wire for submerged arc cladding
- Iron based super alloy optimised for high temperature and corrosion applications
- Suitable for applications where standard Martensitic alloys do not meet life expectancy

APPLICATIONS

WA CORRESIST-S wire was specially designed and manufactured for the cladding of rolls which are just below copper mould and vertical upper segment, in a continuous casting machine, to extend their life.

CONDITIONS OF USE

Current type

DC (+)

Shielding

WAF 325

FLUX DESCRIPTION

WAF 325

Classification	EN 760: S A AB 1 65 DC H5
Basicity index	2.3 (according to Boniszewski)
Granulometry	0.25 - 2.5 mm
Current	DC by preference
Redrying	2 hours at 300°C - 350°C
Packaging	bags (25 kg) or metallic drums (200kg)

OPERATING CONDITIONS

Diameter [mm]	Amperage [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
2.4	200 - 450	350	28 - 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: > 90 %

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