

Technical data sheet <small>011121MBA</small>	Cored welding wire CHROMECORE 414-O	 Welding Alloys
---	--	---

CLASSIFICATION

EN 14700: T Fe7

DESCRIPTION

- Flux-cored tubular wire for self-shielded metal arc hardfacing
- Martensitic stainless steel deposit
- Gives good resistance to thermal shock, corrosion and abrasive wear

APPLICATIONS

- Continuous casting rolls
- Valve seats, sealing closures, pipework elements

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo
0.06	1.3	1.2	13.9	4.0	0.5

Structure: martensite + ferrite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

As-welded hardness: 38 – 43 HRc

CONDITIONS OF USE

Current type	Protection
DC+	Self-shielded

OPERATING CONDITIONS

Diameter [mm]	Current [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
1.6	150 - 350	270	24 - 35	28	25 - 50	25
2.0	250 - 400	300	26 - 35	28	25 - 50	35
2.4	250 - 450	350	26 - 35	28	25 - 50	40
2.8	250 - 450	400	28 - 35	30	25 - 50	40

Recovery: 90 %

WELDING POSITIONS

Flat, half up, half down

PACKAGING

Diameter	≤ 2.4 mm	≥ 2.4 mm	
Standard packaging	EN ISO 544: BS 300 spool	B 450 coil	Drum
Weight	15 kg	25 kg	Up to 330 kg

Other packaging and other diameters: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.