Technical Data Sheet

CHROMECORE 414N-O

Martensitic stainless steel -> Flux cored wire for Self-shielded Flux Cored Arc Welding (FCAW-S)

1 GENERAL INFORMATION

EN 14700: T Fe7

- Nitrogen-containing 13% chromium martensitic stainless steel deposit for optimised corrosion resistance
- The deposit resists corrosion, stress corrosion, erosion, galling, thermal shocks and thermal fatigue
- Extensively used as a cladding alloy for rebuilding steel mill rolls subject to repetitive thermal stresses, corrosion and metal-to-metal wear

Continuous casting rolls, hot-rolling mills, steam turbines, valve seats, etc.

2 ALL WELD METAL PROPERTIES

CHEMICAL ANALYSIS [%]

C	Mn	Si	Cr	Ni	Mo	N
0.08	1.0	1.0	13.5	4.3	0.7	0.09

HARDNESS

40-45 HRC (as welded, three-layers)

3 RECOMMENDED WELDING PARAMETERS

Diameter [mm]	Welding Position	Polarity	Current [A]	Voltage [V]	Stick-out [mm]
1.6	PA / 1G or 1F	DC+	200 - 300	25 - 29	25 ± 5
2.0	PA / 1G or 1F	DC+	220 - 330	26 - 30	25 ± 5
2.4	PA / 1G or 1F	DC+	250 - 350	26 - 30	30 ± 5
2.8	PA / 1G or 1F	DC+	350 - 450	27 - 31	30 ± 5
3.2	PA / 1G or 1F	DC+	400 -500	28 - 32	30 ± 5

WELDING PROTECTION

Self-shielded

WELDING POSITION

4 PACKAGING OPTIONS

Diameter [mm]	1.6 - 2.4	2.4 - 3.2	2.4 - 3.2
Standard packaging (EN ISO 544)	BS 300 spool	B 450 coil	Drum
Weight [kg]	15	25	Up to 330

Other packaging requirements: 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.