

VAUTID 110

Welding rod

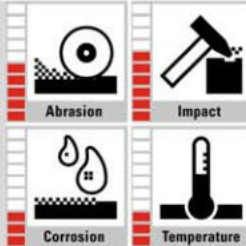
Hardfacing material for abrasion and upstream position welding



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VAUTID Material characteristics



Specification	Welding rod DIN EN 14700 E ZFe6 gkp
Material type Alloy components	Martensitic hard alloy on iron base C – Cr – Mo – V – Fe
Weld deposit characteristics	VAUTID 110 produces abrasion- and shock resistant weld deposit and can be welded in different positions (horizontal, transversal, upward). The weld deposit is magnetic and cannot be machined in hardfaced conditions. Annealing enables machining
Weld deposit properties	Hardness (acc. DIN 32525-4): 57 – 61 HRC*
Recommended applications	Perfectly suited for parts subjected to a combination of shock and abrasion as well as metal-to-metal wear, e.g. punches, knives and guide rails. Well suited for the hardfacing of edges. The various possible welding positions enable regeneration also of installed parts
Standard sizes	Welding rods: Diameter 3,25 / 4,0 / 5,0 / 6,0 mm Packing: 5 kg packages

* subject to common industrial fluctuations

Welding instructions for welding rods:

VAUTID 110 welding rods can be welded with d.c. on the +pole.
The amount of layers should be limited on 2.
It is not necessary to re-dry the electrodes prior to welding.

Diameter (mm)	Voltage (A)
3,25	100 – 120
4,0	120 – 160
5,0	170 – 210
6,0	210 - 250

Welding positions (EN ISO 6947): PA, PB, PC, PF

This data sheet corresponds to the present state of production (October 2016) and can be changed anytime.