

VAUTID 35

Tubular wire

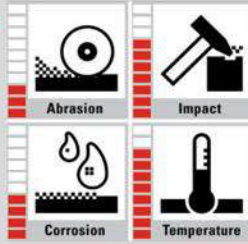
Hardfacing material for continuous casting rollers



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VAUTID Material characteristics



Specification	Tubular wire electrode DIN EN 14700 T Fe7 cpt
Material type Alloy components	Hardfacing material on iron base with Chromium, Nickel and Molybdenum additions Cr – Ni – Mo
Welding deposit characteristics	VAUTID 35 produces a crack-free, martensitic stainless steel weld deposit. Perfectly suited for parts exposed to heat (oxidation), corrosion, impact and medium wear. The weld material can be machined and forged
Weld deposit properties	Hardness of pure welding deposit (acc. DIN 32525-4): approx. 20 HRC Hardness 1. Layer on S235JR (1.0037): approx. 42 - 47 HRC
Recommended applications	Typically applications are build-up layers for continuous casting rollers, valve seats , gate valves and metal to metal applications in general
Standard sizes	Tubular wires: Diameter 2,4 / 2,8 mm Packing: Reels of approx. 25 kg, Drums of approx. 250 kg

* subject to common industrial fluctuations

Welding instructions for tubular wires:

VAUTID 35 tubular wires are welded open-arc without inert gas on the +pole. In order to prevent slag-flow sagging wire-guiding should be preferred. Both the weave bead and the stinger bead techniques can be used. Several layers can be welded

Diameter (mm)	Current (A)	Voltage (V)	Stick out (mm)
1,6	160 – 280	24 – 27	20 – 35
2,0	180 – 310	25 – 28	24 – 45
2,4	220 – 350	26 – 29	24 – 45
2,8	270 – 430	27 – 30	30 – 50
3,2	290 – 470	28 – 30	30 - 55

Welding positions (EN ISO 6947): PA, PB

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