VAUTID 40

Tubular wire and welding rod
Hardfacing material for impact and abrasion

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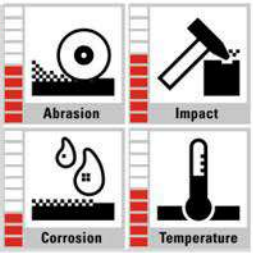
VAUTID Material characterisitcs



Specification	Tubular wire electrode DIN EN 14700 T Fe6 gp Welding rod DIN EN 14700 E Fe6 gp
Material type Alloy components	Medium-alloyed, martensitic Cr – C – hard alloy on iron base C – Cr – Mo – Fe
Weld deposit characteristics	VAUTID 40 produces a hardened, shock- and abrasion-resistant weld deposit. Usually the hardfacing is free of cracks. The weld deposit is magnetic and cannot be machined in welding condition. Annealing enables machining
Weld deposit properties	Hardness of pure welding material (acc. DIN 32525-4): ca. 52 - 56 HRC*
Recommended applications	Perfectly suited for parts subjected to combined shock and abrasion stress, with high shock resistance and low abrasion resistance. VAUTID 40 is also very well suited for metal-to–metal wear applications, e.g. dredger teeth, percussion boring heads, guide rails and wire drawing disks
Standard sizes and packaging	Tubular wires: Diameter: 1,2 / 1,6 / 2,0 / 2,4 / 2,8 / 3,2 mm Packing: Mandrels 15 kg, Reels 25 kg, Drums 250 kg Welding rods: Diameter: 3,25 / 4,0 / 5,0 / 6,0 mm Packing: 5 kg packages

* subject to common industrial fluctuations

Welding instructions for tubular wires:

VAUTID 40 tubular wires are welded without inert gas on the +pole (a.c. is possible). Several layers can be welded.

Diameter (mm)	Current (A)	Voltage (V)	Stick out (mm)
1,2	100 – 220	18 – 22	20 – 30
1,6	160 – 280	24 – 27	20 – 35
2,0	180 – 300	25 – 28	24 – 40
2,4	240 – 380	26 – 29	30 – 45
2,8	280 – 450	27 – 30	30 – 50
3,2	290 – 470	28 – 30	30 - 55

Welding positions (EN ISO 6947): PA, PB

Welding instructions for welding rods:

VAUTID 40 – welding rods can be welded with d.c. on the +pole but also with a.c. Several layers can be welded. It is not necessary to re-dry the electrodes prior to welding.

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

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

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