

CLASSIFICATIONS

EN 14700 : T Fe7
 EN ISO 17633-A : T 13 4 M M 3
 AWS A5 .22 : E C 410 NiMo (mod.)

DESCRIPTION

- Cr-Ni alloyed metal flux cored wire for hardfacing applications
- Can be used joint welding
- Shielding gas: M21

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL)

C: 0.05 | Si: 0.35 | Mn: 0.70 | Cr: 12.0 | Ni: 4.0 | Fe: Rest

MECHANICAL PROPERTIES

Hardness (as welded)
 (HB)

400

BASE MATERIALS

- Steel mili rolls, rollers, pumps and 410 stainless valves.

WELDING POSITIONS



OPERATING DATA

Diameter (mm)	Welding Current (A)	Voltage (V)	Stick-out (mm)
1.60	180 - 210	26.0 - 31.0	25.0 - 30.0

CURRENT TYPE

FCAW / D.C. (+)

OPERATING DATA

Product Code	Diameter x Length (mm) / (inch)		Package Weight (Kg)
2010300025	1.60	0.062"	15