

CATEGORY	FCAW Flux-Cored	
TYPE	Self-Shielded fluxcored CrNiMo wire	
APPLICATIONS	Bridge bearings, sealing surfaces, corrosion, slide ring sealing, centrifuge, continuous casting rolls	
PROPERTIES	The corrosion resistant deposit with a medium hardness is resistant against impact wear as well as permanent stress by heat influence, metal wear and high surface pressure	
CLASSIFICATION	AWS EN ISO W.Nr.	A 5.22: E410NiMoT0-3 14700: T Fe7 1.4351
SUITABLE FOR	1.4317, 1.4313, 1.4407, 1.4414, GX4CrNi13-4, X3CrNiMo13-4, GX5CrNiMo13-4, GX4CrNiMo13-4 ACI Gr. CA 6 NM	

APPROVALS No Approvals Found

WELDING POSITIONS:



### TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	Cr	Ni	Mo
0.05	0.9	1	0.025	14	4.5	0.75

### ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R <sub>p0,2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)	Hardness Rockwell C
As Welded /				Avg. 40

### WELDING PARAMETERS / PACKING

WELDING PARAMETERS	WELDING PARAMETERS	WELDING PARAMETERS	PACKING	PACKING	PACKING
D (MM)	VOLTAGE (V)	CURRENT (A)	SPOOL TYPE	KG / SPOOL	KG / PALLET
1,2	18-26	120-220	S-300	15	1080
1,6	20-26	100-200	S-300	15	1080
2,0	24-28	100-260	B-415	25	900
2,4	26-29	240-380	B-415	25	900

REDRYING TEMPERATURE 140°C / 24 hr

GAS ACCORDING EN 14175