

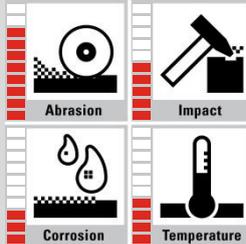
VAUTID 144

Tubular wire

Hardfacing material for higher abrasion and impact

VAUTID®

VAUTID Material characteristics



Specification	Tubular wire electrode DIN EN 14700 T ZFe16 g3
Material type Alloy components	High-chromium-high-carbon hard alloy on iron base with niobium and vanadium additions C – Cr – Nb – V – Fe
Weld deposit characteristics	VAUTID 144 produces a wear-resistant, primary chromium- and niobium-carbide-containing weld deposit which is extremely resistant to abrasion due to the finely dispersed hard niobium – and vanadium-carbides. They exhibit good shock resistance due to the fine microstructure. The material cannot be subjected to flame cutting, offers good resistance to scaling and cannot be machined. The weld deposit exhibits cracks
Weld deposit properties	Hardness (acc. DIN 32525-4): 60 - 63 HRC*
Recommended applications	Perfectly suited for the hardfacing of rollers in the coal, ore and cement industry. Also recommended particularly for the hardfacing of parts subjected to higher abrasion and average shock stress, e.g. dredging bucket front edges, sieves, sand slingers, top coats on dredger teeth and crushing rolls. The application temperatures should not exceed 350 ° Celcius
Standard sizes	Tubular wire: Diameter 1,6 / 2,0 / 2,4 / 2,8 / 3,2 mm Packing: Mandrels 15 kg, Reels 25 kg, Drums 250 kg

* subject to common industrial fluctuations

Welding instructions for tubular wires:

VAUTID 144 tubular wire is welded without inert gas on the +pole (a.c. possible). Weave technique is usual. The arc should be held as short as possible and the thickness of hard-surfacing deposits should be limited to 10 mm. Preheating decreases the generation of stress cracks on the hard-facing

Diameter (mm)	Current (A)	Voltage (V)	Stick out (mm)
1,6	150 – 270	24 – 27	20 – 40
2,0	180 – 300	25 – 28	25 – 40
2,4	230 – 350	26 – 29	25 – 50
2,8	260 – 420	27 – 29	30 – 55
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.

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