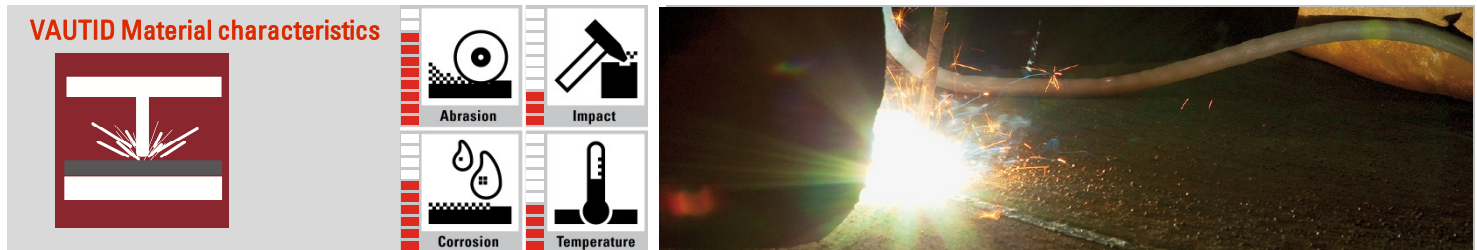


VAUTID 100C

Tubular wire and welding rod

Hardfacing material for abrasion and corrosion

VAUTID®



Specification	Tubular wire electrode Welding rod	DIN EN 14700 T Fe14 cgkz DIN EN 14700 E Fe14 cgkz
Material type Alloy components	Hard alloy on iron-base with high chromium and carbon contents with nickel and molybdenum additions C – Cr – Mo – Ni – Fe	
Weld deposit characteristics	VAUTID 100C produces a corrosion, heat and scale-resistant weld deposit. It is non-magnetic, shock-resistant and can be work hardened. Depending on the part geometry and the preheating temperature the weld deposit exhibits cracks	
Weld deposit properties	Hardness (acc. DIN 32525-4): 43-46 HRC*	
Recommended applications	Recommended particularly for applications requiring good abrasion resistance along with high corrosion and impact resistance that allow little cracking even in multi-layer hardfacings. Substitute of Stellite 6 substitute for parts subjected to shock and wear. Applicable in particular for knives, mixer components, agitator parts in the pulp and paper industry, food processing and vessel engineering	
Standard sizes	Tubular wires:	Diameter 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 100C tubular wire is welded open-arc without inert gas on the +pole. (a.c. possible). Both the weave bead and the stinger bead technique can be used. VAUTID 100C is suited for application on unalloyed and low-alloy steels, Cr-Ni steels and black manganese steel. VAUTID 100C should be welded with short arc and comparably low voltage. Several layers can be welded.

Diameter (mm)	Current (A)	Voltage (V)	Stick out (mm)
1,6	150 – 270	24 – 27	20 – 40
2,0	200 – 310	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

Welding instructions for welding rods:

VAUTID 100C welding rods can be welded with d.c. on the +pole but also with a.c. 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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