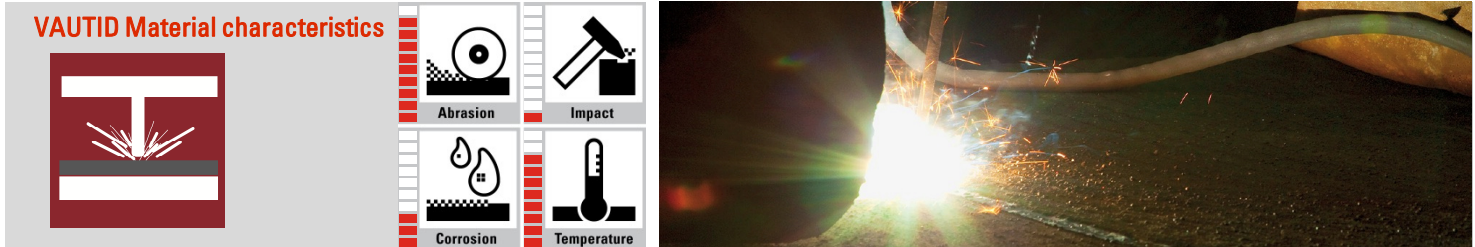


VAUTID 147

Tubular wire and welding rod

Hardfacing material for highest abrasion and high temperatures

VAUTID[®]



Specification	Tubular wire electrode Welding rod	DIN EN 14700 T Fe16 gtz DIN EN 14700 E Fe16 gtz
Material type Alloy components	High-carbon-highest-chromium alloy on iron base with boron additions C – Cr – B – Fe	
Weld deposit characteristics	VAUTID 147 produces a wear-resistant, primary carbide-containing weld material with highest hardness at higher temperatures. The application temperatures should not exceed 850° C. The weld deposit exhibits cracks, cannot be machined and has limited shock resistance	
Weld deposit properties	Hardness (acc. DIN 32525-4): approx. 68 HRC*	
Recommended applications	Recommended particularly for the hardfacing of parts subjected to strong abrasion and average shock stress as well as high temperatures, e.g. fan components, furnace top bell faing, hot dust ducts, screens, sinter crushers	
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 147 tubular wire is welded without inert gas on the +pole (a.c. possible). Weave technique is usual. Preheating of base material and VAUTID 18/8/6 – buffer layers are recommended on hard weldable, massive components. The amount of layers should be limited to 2.

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 instructions for welding rods:

VAUTID 147 welding rods can be welded with d.c. on the +pole but also with a.c. The amount of layers should be limited to 2. It is not necessary to re-dry the electrodes prior to welding.

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

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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