

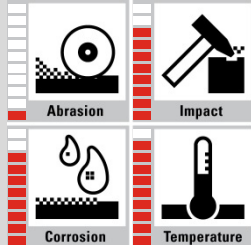
VAUTID 30/9

Welding rod

Hardfacing materials for buffer layers

VAUTID®

VAUTID Material characteristics



Specification	Welding rod DIN EN 14700 E Fe11 cknpz
Material type Alloy components	Ferritic-austenitic steel weld deposit C – Cr – Ni – Fe
Weld deposit characteristics	Uniform, smooth, finely feathered beads. Highly resistant to cracking. Not corrosive, good compatibility with all weldable steel and cast steel types; specially with „difficult to weld steels“. VAUTID 30/9 can be work-hardened. High resistance to pressure, impact and cavitation
Weld deposit properties	Tensile strength: 710 - 820 N/mm ² Elongation A5: 20 - 24% Hardness of pure welding material (acc. DIN 32525-4): approx. 210 HB*
Recommended applications	Buffer layers for welding of hardfacings Buffer electrode for the joint welding of hardfaced plates
Standard sizes	Welding rods: Diameter: 3,25 / 4,0 / 5,0 / 6,0 mm Packing: 5 kg packages

* subject to common industrial fluctuations

Welding instruction for welding rods:

VAUTID 30/9 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

Welding positions (EN ISO 6947): PA, PB

This data sheet corresponds to the present state of production (October 2016) and can be changed anytime.