

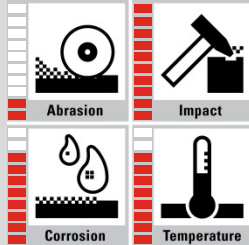
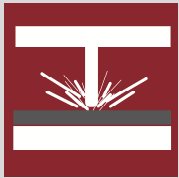
# VAUTID 60

Tubular wire

Hardfacing material for impact, shock and buffer layers

VAUTID®

## VAUTID Material characteristics



<b>Specification</b>	Tubular wire electrode DIN EN 14700 T Fe9 kp
<b>Material type</b> <b>Alloy components</b>	Manganese steel, alloy on iron base with chromium additions C – Cr – Mn – Fe
<b>Weld deposit characteristics</b>	VAUTID 60 produces an austenitic (non-magnetic) tough and crack-free weld deposit. Shock impact result in superficial work-hardening. The weld deposit is characterized by its good compatibility with all weldable steels. The hardfacing material is not suited for flame-cutting. Crack-free hardfacing up to 10 mm thickness is possible
<b>Weld deposit properties</b>	Tensile strength: 850 N / mm <sup>2</sup> Hardness: (acc.DIN 32525-4): 190 – 230 HB* in welding condition 40 – 50 HRC* work-hardened
<b>Recommended applications</b>	Perfectly suited for tough and pressure-resistant buffer layers and for the hardfacing of parts which are mainly subjected to impact as well as for the regeneration of components made from black manganese steel, e.g. hammers, beating arms and crusher rolls
<b>Standard sizes</b>	Tubular wires: 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 60 tubular wires are welded without inert gas on the +pole (a.c. possible). The wire allows welding with an extremely long stick out for a higher deposition rate. VAUTID 60 is to be welded with comparably low voltage. Several layers can be welded.

Diameter (mm)	Current (A)	Voltage (V)	Stick out (mm)
1,6	130 – 260	20 – 22	20 – 35
2,0	170 – 320	20 – 22	25 – 40
2,4	190 – 380	22 – 24	30 – 45
2,8	230 – 450	22 – 24	35 – 50
3,2	290 – 470	28 – 30	30 - 55

Welding positions (EN ISO 6947): PA

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

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