

AX-FD 4015-G

Classification

DIN 14700	T Fe 7
Material-no.:	1.4015
AWS-No.:	430

General Characteristics

The tough and corrosion resistant overlay is well suited for parts that encounter wear from sea water plant and power plant operation. This acid corrosion resistant wire has a 17% Cr content which forms the wearing analysis with a low carbon content of 0,1%. The weld parameters should be chosen with a low heat input as possible due to coarse grain formation in 17% Cr-alloys.

Application: Bridge bearings, sealing surfaces for service temperatures up to 450°C. corrosion slide ring sealing, roller bearings, valves, continuous casting rolls, Cr-alloying buffer layers..

Typical All Weld Metal Analysis:

C	Cr	Fe
0,1	17,0	Bal.

Typical All Weld Metal Mechanical Properties:

Hardness: 220 – 240 HB

Parameter:

Diameter	Voltage	Amps
1,2	20-24	150-200
1,6	22-26	180-240
2,0	25-27	220-260
2,4	25-27	260-300
2,8	26-28	280-340

Forms of Delivery:

Coil „BS300“ = 15kg	Coil „BS450“ = 25kg	Drums = 300kg
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G = gas shielded

(also available OA = gasless, SA = Submerged Arc)