


VAUTID 100


Tubular wire and welding rod

Hardfacing material for high abrasion and moderate temperatures




VAUTID Material characteristics







Abrasion




Impact



Corrosion



Temperature



Specification	Tubular ire electrode Welding rod	DIN EN 14700 T ZFe15 g DIN EN 14700 E ZFe15 g
Material type Alloy components	High-chrome-high-carbon hard alloy on iron base C – Cr – Fe	
Weld deposit characteristics	VAUTID 100 produces a wear-resistant, austenitic, primary carbide-containing weld deposit. It is very resistant on abrasion. The material cannot be flame cut, offers good resistance to scaling and cannot be machined. The weld deposit exhibits cracks	
Weld deposit properties	Hardness (acc. DIN 32525-4): 60-63 HRC*	
Recommended applications	Recommended particularly for the hardfacing of parts subjected to strong abrasion and average shock stress, e.g. screws, dredging bucket front edges, sieves, stirrer blades, sand slingers, top coats on dredger teeth and crushing rolls The application temperatures should not exceed 350 ° C	
Standard sizes	Tubular wires:	Diameter 1,2 / 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 100 is welded without inert gas on the +pole (a.c. possible). Weave technique is usual. The arc should be held as short as possible. Preheating decreases the generation of stress cracking on the hardfacing.

Diameter (mm)	Current (A)	Voltage (V)	Stick out (mm)
1,2	100 – 220	18 – 22	20 – 30
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 positions (EN ISO 6947): PA, PB

Welding instructions for welding rods::

VAUTID 100 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. VAUTID 100 welding rods are high-performance electrodes with a deposition rate of 200 %.

Diameter (mm)	Current (A)
3,25	100 – 120
4,0	120 – 160
5,0	170 – 210
6,0	230 – 250

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