VAUTID 30/9
Welding rod
Hardfacing materials for buffer layers

Specification

<table>
<thead>
<tr>
<th>Material type</th>
<th>Welding rod DIN EN 14700 E Fe11 cknpz</th>
</tr>
</thead>
</table>

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/mm²
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

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.

<table>
<thead>
<tr>
<th>Diameter (mm)</th>
<th>Current (A)</th>
</tr>
</thead>
<tbody>
<tr>
<td>3,25</td>
<td>100 – 120</td>
</tr>
<tr>
<td>4,0</td>
<td>120 – 160</td>
</tr>
<tr>
<td>5,0</td>
<td>170 – 210</td>
</tr>
<tr>
<td>6,0</td>
<td>210 - 250</td>
</tr>
</tbody>
</table>

Welding positions (EN ISO 6947): PA, PB

* subject to common industrial fluctuations