VAUTID 80
Tubular wire
Hardfacing material for high impact and abrasion

VAUTID Material characteristics

<table>
<thead>
<tr>
<th>Abrasion</th>
<th>Impact</th>
<th>Corrosion</th>
<th>Temperature</th>
</tr>
</thead>
</table>

Specification
Tubular wire electrode DIN EN 14700 T Z Fe14gp

Material type
Alloy components
Sub-eutectic Cr-Mo-C hard alloy on Fe-basis

Weld deposit characteristics
VAUTID 80 is a high-performance tubular wire with a deposition rate of 15kg/h and produces an overlay resistant to abrasion and impact. The weld deposit cannot be machined. Machining of the annealed material is possible. The weld material exhibits cracks

Weld deposit properties
Hardness: Pure welding material (acc. DIN 32525-4): approx. 50 – 56 HRC*

Recommended applications
Perfectly suited for parts subjected to combined impact and abrasive stresses, e.g. cone crushers, pick hammers, dredger teeth, crusher rolls and guide rails

Standard sizes
Tubular wires: Diameter 1,6 / 2,0 / 2,4 / 2,8 / 3,2 mm
Packing: Mandrels 15 kg, Reels 25 kg, Drums 250 kg

Welding instructions for tubular wires:

VAUTID 80 tubular wires are welded open-arc without inert gas on the pole (a.c. possible). Both the weave bead and stinger bead technique can be used. Weaving and preheating prevent cracking. The height of the hardfacing should be limited to 50-60 mm.

<table>
<thead>
<tr>
<th>Diameter (mm)</th>
<th>Current (A)</th>
<th>Voltage (V)</th>
<th>Stick out (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>1,6</td>
<td>200 – 400</td>
<td>24 – 30</td>
<td>20 – 40</td>
</tr>
<tr>
<td>2,0</td>
<td>300 – 500</td>
<td>25 – 30</td>
<td>25 – 45</td>
</tr>
<tr>
<td>2,4</td>
<td>400 – 550</td>
<td>26 – 33</td>
<td>25 – 50</td>
</tr>
<tr>
<td>2,8</td>
<td>450 – 600</td>
<td>27 – 35</td>
<td>30 – 55</td>
</tr>
<tr>
<td>3,2</td>
<td>500 – 650</td>
<td>30 – 40</td>
<td>35 – 60</td>
</tr>
</tbody>
</table>

Welding positions (EN ISO 6947): PA, PB

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