

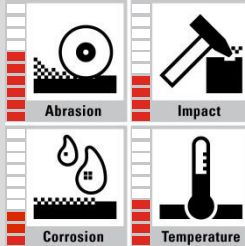
VAUTID 80

Tubular wire

Hardfacing material for high impact and abrasion

VAUTID®

VAUTID Material characteristics



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

* subject to common industrial fluctuations

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.

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

Welding positions (EN ISO 6947): PA, PB

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

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