

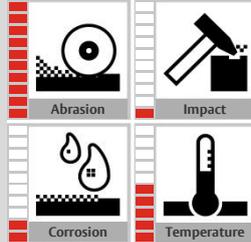
VAUTID Ultra 304

Tubular Wire

Hardfacing material for extreme abrasion

VAUTID®

VAUTID Material characteristics



Specification	Tubular Wire Electrode DIN EN 14700 T Fe20 g
Material type Alloy components	Hard tungsten carbides embedded in a wear-resistant ledeburitic iron matrix. C – Fe – W2C – WC
Weld deposit characteristics	VAUTID Ultra 304 is a hardened, extremely wear resistant and relatively brittle weld deposit that may exhibit cracks. The deposit is magnetic and cannot be machined
Weld deposit properties	Hardness in 1st layer: 66 – 69 HRC* (DIN 32525-4)
Recommended applications	Suited for parts subjected to highest abrasion and wear with low impact stress such as strippers, pressing screw edges, boring rod guiding devices, mixer blades, plough blades.
Standard sizes	Diameters: 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:

VAUTID Ultra 304 is usually welded at the +pole without inert gas. The hardfacing material is preferably welded by stringer bead technique and with low current. Weave bead technique and high current lead to increased cracking and brittleness of the hardfacing due to the mostly undesired surface melting of the tungsten carbides. To prevent excessive brittleness, weld only one hardfacing layer.

Diameter (mm)	Current (A)	Voltage (V)	Stick out (mm)
1,6	100 – 150	20 – 23	20 – 35
2,0	130 – 180	22 – 25	20 – 35
2,4	170 – 220	24 – 27	25 – 40
2,8	200 – 320	25 – 28	24 – 40
3,2	240 – 360	28 – 32	30 – 45

Welding position (EN ISO 6947): PA

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