

Prepared by David P	Qualified by Siva P	Approved by Umesh M	Reg no EN2090011	Cancelling EN2090010	Reg date 2024-08-15	Page 1 (2)
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GENERAL

Gas-shielded metal-cored continuous wire for applications involving impact, compressive loads and low stress abrasive wear. The alloy deposits high-alloy corrosion-resistant martensitic steel specifically intended for surfacing of cast rollers in continuous steel casting mills as a wear-resistant layer. The machinable deposit exhibits excellent resistance to corrosion, scaling, heat and metal-to-metal friction. As-welded hardness of three-layer deposit is in the range of 48 – 50 HRc.

Polarity: DCEP

Alloy Type : Martensitic Stainless Steel

Flux Type : NA

WELDING POSITIONS



1



3

CLASSIFICATIONS Electrode

EN 14700 : TFe7

APPROVALS

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max	Nom
C	0.1	0.3	0.2
Si	0.1	1.0	0.5
Mn	0.5	1.5	1.2
Cr	11.0	13.0	12.0
Mo	1.0	1.5	1.0
Ni	1.0	2.0	1.4
Nb	0.2	1.0	0.3
V	0.1	0.5	0.2
Fe		Balance	Balance



Product Data Sheet

E 'Manual metal-arc welding'

EWAC G-13CR

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MECHANICAL PROPERTIES OF WELD METAL

Hardness	Min	Max	Nom
As-deposited hardness	44 HRc	52 HRc	50 HRc

Comments:

ECONOMICS & CURRENT DATA

Wire Dia (mm)	Voltage (V)	Current (A)	Stick-out (mm)	Shielding gas
1.6	26-30	300-360	10 - 15	Ar:CO2 (80:20) / 100% CO2

OTHER DATA

Clean weld area. Remove worn-out and fatigued metal by machining. Pre-heat high carbon steel and heavy sections to 250 – 350 °C. Chip to remove slag islands/scale between passes. Stress-relieve components at 550 Deg C for 4 hrs or desired period depending on the size of the job. Allow to cool under insulation.
