

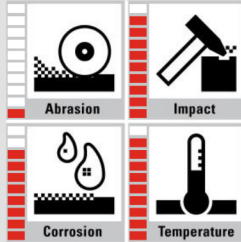
VAUTID 18/8/6

Tubular wire and welding rod

Hardfacing material for impact, pressure and buffer layers



VAUTID Material characteristics



Specification	Tubular wire electrode Welding rod	DIN EN 14700 T Fe10 cknpz DIN EN 14700 E Fe10 cknpz
Material type Alloy components	chromium-nickel-manganese-austenite on iron-base C – Cr – Ni – Mn – Fe	
Weld deposit characteristics	VAUTID 18/8/6 produces corrosion-resistant, austenitic steel weld deposit with high elongation values. The weld deposit is tough and can be work-hardened	
Weld deposit properties	Tensile strength: Elongation A5: Hardness of pure welding material (DIN 32525-4):	approx. 580 N/mm ² approx. 40% 180-200 HB* approx. 38 HRC* (work-hardened)
Recommended applications	Buffer layers for welding on black manganese steel, for welding on hardenable steel and for welding of hardfacings. Hardfacing on rails, switches, tumblers, striking pins, components subjected to thermal stress, e.g. in rockwool production	
Standard sizes and packaging:	Tubular wire: Packing: Welding rods: Packing:	Diameters: 1,6 / 2,0 / 2,4 / 2,8 / 3,2 mm Mandrels approx. 15 kg, Reels of approx. 25 kg, Drums of approx. 250 kg Diameters 3,25 / 4,0 / 5,0 / 6,0 mm 5 kg packages

* subject to common industrial fluctuations

Welding instructions for tubular wires:

VAUTID 18/8/6 tubular wires are welded open-arc without inert gas on the +pole, usually with string bead technique. Restrict intermediate layer temperatures to a maximum of 450° C where demands are made on the the weld deposit. When welding on black manganese steel the intermediate layer temperature may not exceed 300° C. Cool if necessary.

Diameter (mm)	Current (A)	Voltage (V)	Stick out (mm)
1,6	100 – 220	26 – 28	20 – 35
2,0	180 – 310	26 – 28	25 – 35
2,4	200 – 240	25 – 29	30 – 40
2,8	320 – 430	26 – 30	30 – 45
3,2	290 – 470	28 – 30	30 – 55

Welding positions (EN ISO 6947): PA, PB

Welding instructions for welding rods:

VAUTID 18/8/6 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.
VAUTID-18/8/6 welding rods are high-performance electrodes with a deposition rate of 170%.

Diameter (mm)	Current (A)
3,25	100 – 200
4,0	120 – 160
5,0	170 – 210
6,0	210 - 250

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

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