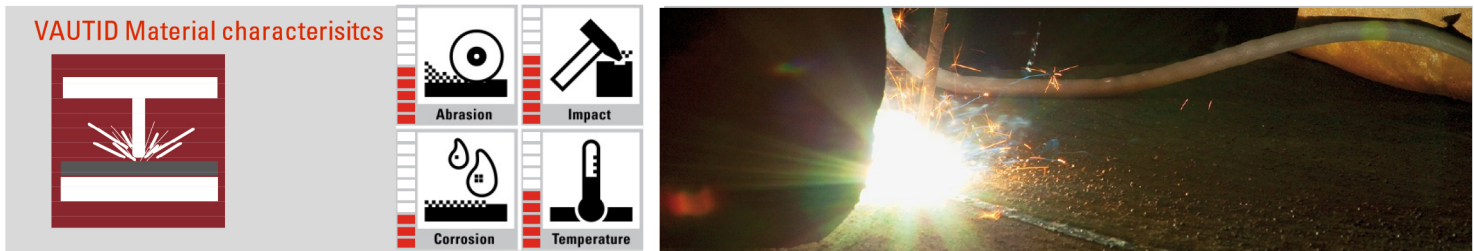


# VAUTID 40

Tubular wire and welding rod  
Hardfacing material for impact and abrasion



<b>Specification</b>	Tubular wire electrode DIN EN 14700 T Fe6 gp Welding rod DIN EN 14700 E Fe6 gp
<b>Material type</b> <b>Alloy components</b>	Medium-alloyed, martensitic Cr – C – hard alloy on iron base C – Cr – Mo – Fe
<b>Weld deposit characteristics</b>	VAUTID 40 produces a hardened, shock- and abrasion-resistant weld deposit. Usually the hardfacing is free of cracks. The weld deposit is magnetic and cannot be machined in welding condition. Annealing enables machining
<b>Weld deposit properties</b>	Hardness of pure welding material (acc. DIN 32525-4): ca. 52 - 56 HRC*
<b>Recommended applications</b>	Perfectly suited for parts subjected to combined shock and abrasion stress, with high shock resistance and low abrasion resistance. VAUTID 40 is also very well suited for metal-to-metal wear applications, e.g. dredger teeth, percussion boring heads, guide rails and wire drawing disks
<b>Standard sizes and packaging</b>	Tubular wires: Diameter: 1,2 / 1,6 / 2,0 / 2,4 / 2,8 / 3,2 mm Packing: Mandrels 15 kg, Reels 25 kg, Drums 250 kg Welding rods: Diameter: 3,25 / 4,0 / 5,0 / 6,0 mm Packing: 5 kg packages

\* subject to common industrial fluctuations

## Welding instructions for tubular wires:

VAUTID 40 tubular wires are welded without inert gas on the +pole (a.c. is possible). Several layers can be welded.

Diameter (mm)	Current (A)	Voltage (V)	Stick out (mm)
1,2	100 – 220	18 – 22	20 – 30
1,6	160 – 280	24 – 27	20 – 35
2,0	180 – 300	25 – 28	24 – 40
2,4	240 – 380	26 – 29	30 – 45
2,8	280 – 450	27 – 30	30 – 50
3,2	290 – 470	28 – 30	30 - 55

## Welding instructions for welding rods:

VAUTID 40 – welding rods can be welded with d.c. on the +pole but also with a.c. Several layers can be welded. It is not necessary to re-dry the electrodes prior to welding.

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

Welding positions (EN ISO 6947): PA, PB

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