VAUTID 100Mo
Tubular wire
Hardfacing material for high abrasion and moderate temperatures

VAUTID Material characteristics

Specification
Tubular wire electrode  DIN EN 14700 T ZFe15 g

Material type
Alloy components
High-chrome-high-carbon hard alloy on iron base with molybdenum additions
C – Cr – Mo – Fe

Weld deposit characteristics
VAUTID 100Mo produces a war-resistant, austenitic, primary carbide-containing weld deposit. It is very resistant to abrasion. The material cannot be flame cut, offers good resistance to scaling and cannot be machined. The weld deposit exhibits cracks

Weld deposit properties
Hardness (acc. DIN 32525-4): 60-65 HRC*

Recommended applications
Recommended particularly for the hardfacing of parts subjected to strong abrasion and average shock stress, e.g. screws, sieves, stirrer blades, sand slingers, top coat on dredger teeth and crushing rolls. The application temperatures should not exceed 350 °C

Standard sizes
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 instructions for tubular wires:

VAUTID 100Mo is welded without inert gas on the +pole (a.c. possible). Weave technique is usual. The arc should be held as short as possible. Preheating decreases the generation of stress cracking on the hardfacing.

<table>
<thead>
<tr>
<th>Diameter (mm)</th>
<th>Current (A)</th>
<th>Voltage (V)</th>
<th>Stick out (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>1,2</td>
<td>100 – 220</td>
<td>18 – 22</td>
<td>20 – 30</td>
</tr>
<tr>
<td>1,6</td>
<td>150 – 270</td>
<td>24 – 27</td>
<td>20 – 40</td>
</tr>
<tr>
<td>2,0</td>
<td>180 – 300</td>
<td>25 – 28</td>
<td>25 – 40</td>
</tr>
<tr>
<td>2,4</td>
<td>230 – 350</td>
<td>26 – 29</td>
<td>25 – 50</td>
</tr>
<tr>
<td>2,8</td>
<td>260 – 420</td>
<td>27 – 29</td>
<td>30 – 55</td>
</tr>
<tr>
<td>3,2</td>
<td>290 – 470</td>
<td>28 – 30</td>
<td>30 – 55</td>
</tr>
</tbody>
</table>

Welding positions (EN ISO 6947): PA, PB

* subject to common industrial fluctuations

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