VAUTID 110
Welding rod
Hardfacing material for abrasion and upstream position welding

VAUTID Material characteristics

**Specification**
- **Welding rod** DIN EN 14700 E ZFe6 gkp

**Material type**
- **Alloy components**
  - Martensitic hard alloy on iron base
  - C – Cr – Mo – V – Fe

**Weld deposit characteristics**
- VAUTID 110 produces abrasion- and shock resistant weld deposit and can be welded in different positions (horizontal, transversal, upward). The weld deposit is magnetic and cannot be machined in hardfaced conditions. Annealing enables machining.

**Weld deposit properties**
- Hardness (acc. DIN 32525-4): 57 – 61 HRC*

**Recommended applications**
- Perfectly suited for parts subjected to a combination of shock and abrasion as well as metal-to-metal wear, e.g. punches, knives and guide rails. Well suited for the hardfacing of edges. The various possible welding positions enable regeneration also of installed parts.

**Standard sizes**
- **Welding rods:** Diameter 3,25 / 4,0 / 5,0 / 6,0 mm
- **Packing:** 5 kg packages

**Welding instructions for welding rods:**
- VAUTID 110 welding rods can be welded with d.c. on the +pole.
- The amount of layers should be limited on 2.
- It is not necessary to re-dry the electrodes prior to welding.

<table>
<thead>
<tr>
<th>Diameter (mm)</th>
<th>Voltage (A)</th>
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<tbody>
<tr>
<td>3,25</td>
<td>100 – 120</td>
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<tr>
<td>4,0</td>
<td>120 – 160</td>
</tr>
<tr>
<td>5,0</td>
<td>170 – 210</td>
</tr>
<tr>
<td>6,0</td>
<td>210 – 250</td>
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</tbody>
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Welding positions (EN ISO 6947): PA, PB, PC, PF

* subject to common industrial fluctuations

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

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