

| Classifications  |        |               |            |                            |           |  |               |                    |  |
|--|--------|---------------|------------|----------------------------|-----------|--|---------------|--------------------|--|
| EN14700  |        |               |            |                            |           |  |               |                    |  |
| T Fe7  |        |               |            |                            |           |  |               |                    |  |
| Characteristics and typical fields of application  |        |               |            |                            |           |  |               |                    |  |
| <ul style="list-style-type: none"><li>•SAW flux cored wire for hard facing. Suitable for SK-C Record SA flux.</li><li>•Martensitic alloy designed to give an outstanding resistance to abrasion, heavy impact, abrasive erosion and crack. Post welding heat treatment and forging strike can be done.</li><li>•Cable sheaves, bed knives, steel mill rolls, crane wheels, forging dies...</li></ul> |        |               |            |                            |           |  |               |                    |  |
| Typical analysis of all-weld metal   |        |               |            |                            |           |  |               |                    |  |
| C  | Si     | Mn            | Cr         | Mo                         | W         |  |               |                    |  |
| 0.1  | 0.4    | 2.0           | 6.0        | 2.0                        | 2.0       |  |               |                    |  |
| Mechanical properties of all-weld metal – typical values (min. values)   |        |               |            |                            |           |  |               |                    |  |
|  | PWHT   |               | Shield gas |                            | As Welded |  | Work-hardened |                    |  |
|  | (°C/h) |               |            |                            | (HRC)     |  | (HRC)         |                    |  |
| Typical  | -      |               | -          |                            | 44        |  | -             |                    |  |
| Guarantee  | -      |               | -          |                            | 42-47     |  | -             |                    |  |
| General Characteristics  |        |               |            |                            |           |  |               |                    |  |
| Microstructure   |        | Machinability |            | Oxyacetylene cutting       |           | Deposit thickness                      |               | Shield gas or Flux |  |
| Martensite   |        | Grinding only |            | Flame cutting is difficult |           | Depends upon application and procedure |               | SK-C Record SA     |  |
| Operating Data   |        |               |            |                            |           |  |               |                    |  |
| Dia.(mm)   |        | Current(A)    |            | Voltage(V)                 |           | Stick-out(mm)                          |               |                    |  |
| 3.2  |        | 325(450)-500  |            | 28-32                      |           | 30-35                                  |               |                    |  |