

## Classifications

EN14700

T Z Fe1

## Characteristics and typical fields of application

- SAW flux cored wire for hard facing. Suitable for SK-C Record SA flux.
- Suitable for any steels (can be welded), except 14Mn% steel. Good machinability.
- Crawler tractor links, crane wheels, shafts, buffer layer for continuous casting rolls, mine car wheels...

## Typical analysis of all-weld metal

C	Si	Mn	Cr	Mo					
0.1	-	1.0	1.0	0.5					

## Mechanical properties of all-weld metal – typical values (min. values)

	PWHT	Shield gas	As Welded	Work-hardened	
	(°C/h)		(HB)	(HB)	
Typical	-	-	241	-	
Guarantee	-	-	200-260	-	

## General Characteristics

Microstructure	Machinability	Oxyacetylene cutting	Deposit thickness	Shield gas or Flux
Bainite	Good	Possible	Depends upon application and procedure used	SK-C Record SA

## Operating Data

Dia.(mm)	Current(A)	Voltage(V)	Stick-out(mm)	
3.2	400-500	28-32	30-35	