

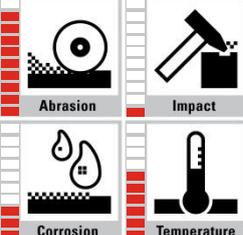
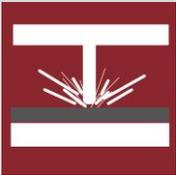
VAUTID 150



Tubular wire and welding rod
Hardfacing material for extreme abrasion and wear



VAUTID Material characteristics



Specification	Tubular wire electrode Welding rod	DIN EN 14700 T ZFe15 g DIN EN 14700 E ZFe15 g
Material type Alloy components	High-chrome-high-carbon hard alloy with boron-additive on iron base C – Cr – B – Fe	
Weld deposit characteristics	VAUTID 150 produces weld deposits of a particularly high hardness. Boride and carbide inclusions generate the high resistance against abrasion. The shock resistance is low and deformation of the parts after hardfacing is only limited. The weld deposit exhibits cracks due to the brittleness of the material. Machining is not possible	
Weld deposit properties	Hardness (acc. DIN 32525-4): approx. 63 HRC*	
Recommended applications	Recommended particularly for the hardfacing of parts subjected to extreme abrasion and little shock stress, e.g. compressing and conveying screws, dust ducts, parts of sifters and cyclones, chutes	
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 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 150 tubular wires are welded without inert gas on the +pole and with a short arc. Weave technique is usual. Apply only 2 layers.

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

Welding instructions for welding rods:

VAUTID 150 welding rods can be welded with d.c. on the +pole but also with a.c. Only one layer should be applied. It is not necessary to re-dry the electrodes prior to welding.

VAUTID 150 welding rods are high-performance electrodes with a deposition rate of 210%.

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



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Welding positions (EN ISO 6947): PA, PB

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