WEARcore 741-O (SK 741-O)
open arc flux cored wire

Classifications

<table>
<thead>
<tr>
<th>EN 14700</th>
<th>DIN 8555</th>
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<tbody>
<tr>
<td>T Fe7</td>
<td>MF 5-GF-45-C</td>
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</tbody>
</table>

Characteristics

Alloy depositing a ferritic-martensitic steel containing 13 % Chromium, 5 % Nickel and 1 % Molybdenum designed to resist metal-to-metal wear, corrosion and thermal fatigue fire cracking.

Microstructure: Martensite + 10 % Ferrite

Machinability: Good with carbide tipped tools

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: Depends upon application and procedure used

Field of use

Continuous casting rollers.

Typical analysis in %

<table>
<thead>
<tr>
<th>C</th>
<th>Mn</th>
<th>Si</th>
<th>Cr</th>
<th>Ni</th>
<th>Mo</th>
<th>Fe</th>
</tr>
</thead>
<tbody>
<tr>
<td>0.02</td>
<td>0.6</td>
<td>0.6</td>
<td>12.6</td>
<td>5.2</td>
<td>0.8</td>
<td>balance</td>
</tr>
</tbody>
</table>

Typical mechanical properties

Hardness as welded: 43 HRC

Recommended welding parameters

<table>
<thead>
<tr>
<th>Wire diameter [mm]</th>
<th>Amperage [A]</th>
<th>Voltage [V]</th>
<th>Stick-Out [mm]</th>
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</thead>
<tbody>
<tr>
<td>1.6</td>
<td>180 – 200</td>
<td>26 – 29</td>
<td>35 – 40</td>
</tr>
<tr>
<td>2.4</td>
<td>250 – 300</td>
<td>26 – 29</td>
<td>35 – 40</td>
</tr>
<tr>
<td>2.8</td>
<td>300 – 350</td>
<td>26 – 29</td>
<td>35 – 40</td>
</tr>
</tbody>
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