Martentic STS Type

Conformances

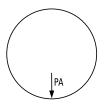
Applications

· Continuous casting rolls, steel mill rolls

Features

- Submerged arc type hardfacing wire
- · Martensitic stainless steel type

Welding Position



Current

DC+

Welding Process

SAW(with S-717/S-401HF flux)

Diameter / Packaging

Diameter	Coil	Pac		
mm (in)	25kg (55lbs)	150kg (330lbs)		
2.4 (3/32)	√	√	V	
3.2 (1/8)	√	\checkmark	$\sqrt{}$	

Typical Chemical Composition of All-Weld Metal (%)

	С	Si	Mn	Cr	Ni	Mo	Nb	V
As welded with 2.4/3.2mm wire	0.11	0.6	1.5	13.8	2.8	1.1	0.2	0.3

Typical Mechanical Properties of All-Weld Metal

	Rockwell Hardness(HRc) (≥3layers)		
On Mild Steel (2.4/3.2mm)	42~46		

Typical Welding Parameters

Diameter, Polarity CTWD Shielding Gas mm (in)		Wire Feed Speed Amp. m/min (in/min) (A)		Volt. (V)	Deposition Rate kg/hr (lb/hr)	
		1.4 (55)	350	28	3.8 (8.4)	
Submerged Arc 25 (1)	25 (1)	1.7 (66)	390	30	4.6 (10.1)	
		1.8 (72)	430	31	5.2 (11.4)	