VAUTID 30

Tubular wire and welding rod
Hardfacing material for impact and buffer layers

VAUTID®

VAUTID Material characteristics

Abrasion Impact
Corrosion Temperature

Specification	Tubular wire electrode DIN EN 14700 T Fe1 p Welding rod DIN EN 14700 E Fe1 p
Material type **Alloy components**	Low-alloyed hardfacing material on iron base with Chromium and Molybdenum additions C – Cr – Mo – Fe
Welding deposit characteristics	VAUTID 30 produces a crack-free, ferritic/perlitic weld deposit with high compressive strength. The weld material can be machined, forged and exhibits an elongation of approx 10%
Weld deposit properties	Elongation A5: approx. 10% Hardness of pure welding deposit (acc. DIN 32525-4): approx. 150 - 450 HB*
Recommended applications	Typically applications are build-up layers for hardfacings, regeneration of crane wheels, rope pulleys and rails
Standard sizes	Tubular wires: Diameter 1,2 / 1,6 / 2,0 / 2,4 / 2,8 / 3,2 mm Packing: Mandrels of approx. 15 kg, Reels of approx. 25 kg, Drums of approx. 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 30 tubular wires are welded open-arc without inert gas on the +pole or with a.c. Both the weave bead and the stinger bead techniques can be used. Several layers can be welded..

Diameter (mm)	Current (A)	Voltage (V)	Stick out (mm)
1,6	160 – 280	24 – 27	20 – 35
2,0	180 – 310	25 – 28	24 – 45
2,4	220 – 350	26 – 29	24 – 45
2,8	270 – 430	27 – 30	30 – 50
3,2	290 – 470	28 – 30	30 - 55

Welding positions (EN ISO 6947): PA, PB

Welding instructions for welding rods:

VAUTID 30 – welding rods can be welded open-arc with d.c. on the +pole but also with a.c. Several layers can be welded.
It is not necessary to re-dry the electrodes prior to welding.

VAUTID 30 – welding rods offer a deposition efficiency of 130%.

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

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