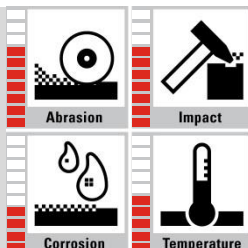# VAUTID 90

Tubular wire and welding rod
Hardfacing material for hard and ductile layers, especially in case of combined erosion, abrasion and impact loads

VAUTID®

VAUTID Material characteristics

Abrasion | Impact
Corrosion | Temperature

Specification	Tubular wire electrode	DIN EN 14700 T Fe15 g
	Welding rod	DIN EN 14700 E Fe15 g

Material type Alloy components	Eutectic Cr – Mo – Ni – C alloy on iron base
Weld deposit characteristics	VAUTID 90 produces a very fine, eutectic and self-hardened welding deposit, resistant to abrasion and impact. The weld deposit cannot be machined in welding conditions. Crack-free hardfacings up to 5 mm thickness are possible
Weld deposit properties	Hardness (acc. DIN 32525-4): approx. 57 - 62 HRC
Recommended applications	Perfectly suited for parts subjected to combined shock and abrasive stress Due to the very fine eutectic microstructure also perfectly suited for applications with erosive stress (aqueous or oleaginous solutions with abrasive fines/jet-wear Especially suited for use in sugarcane- and palm-oil industry applications
Standard sizes	Tubular wires: Diameter 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 mm Packing: 5 kg packages

* subject to common industrial fluctuations

Welding instructions for tubular wires:

VAUTID 90 is welded without inert gas on the +pole (a.c. possible). Weave and stringer technique is possible. Preheating and weave technique decrease the generation of stress cracking on the hardfacing.

Diameter (mm)	Current (A)	Voltage (V)	Stick out (mm)
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 90 welding rods can be welded with d.c. on the +pole but also with a.c.. It is not necessary to re-dry the electrodes prior to welding.

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

Welding positions (EN ISO 6947): PA, PB

This data sheet corresponds to the present state of production (September 2018) and can be changed anytime.