

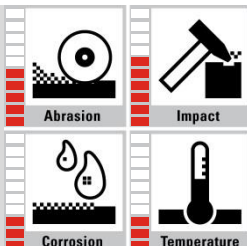
# VAUTID 110

Welding rod

Hardfacing material for abrasion and upstream position welding

VAUTID®

## VAUTID Material characteristics



<b>Specification</b>	Welding rod DIN EN 14700 E ZFe6 gkp
<b>Material type</b> <b>Alloy components</b>	Martensitic hard alloy on iron base C – Cr – Mo – V – Fe
<b>Weld deposit characteristics</b>	VAUTID 110 produces abrasion- and shock resistant weld deposit and can be welded in different positions (horizontal, transversal, upward). The weld deposit is magnetic and cannot be machined in hardfaced conditions. Annealing enables machining
<b>Weld deposit properties</b>	Hardness (acc. DIN 32525-4): 57 – 61 HRC*
<b>Recommended applications</b>	Perfectly suited for parts subjected to a combination of shock and abrasion as well as metal-to-metal wear, e.g. punches, knives and guide rails. Well suited for the hardfacing of edges. The various possible welding positions enable regeneration also of installed parts
<b>Standard sizes</b>	Welding rods: Diameter 3,25 / 4,0 / 5,0 / 6,0 mm Packing: 5 kg packages

\* subject to common industrial fluctuations

## Welding instructions for welding rods:

VAUTID 110 welding rods can be welded with d.c. on the +pole.  
The amount of layers should be limited on 2.  
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
6,0	210 - 250

Welding positions (EN ISO 6947): PA, PB, PC, PF

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

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