

Pronamic® H1 wire

Pronamic® H1 wire is a self-shielded flux-cored wire for welding.

The undiluted deposit contains dense and uniform distribution of primary chromium carbides and eutectic carbides of the M_7C_3 type. The surface appearance is typical for this type of hardface, with a family of stress-relief cracks ("check cracks").

Applications

Pronamic® H1 wire is used for

- manufacturing of Pronamic® tires and grinding plates for vertical mills
- refurbishment of Pronamic® tires and grinding plates, even over existing worn deposits, using Pronamic® approved procedures
- refurbishment of worn high chromium white irons, using Pronamic® approved procedures

Restriction: Pronamic® H1 wire should not be applied over bare steel castings.

Specifications

Pronamic® H1 wire complies with EN14700, type T Z Fe16.

Typical chemical composition (wt. %) of undiluted weld metal				
C	Si	Mn	Cr	Fe
5.5	1.2	0.3	27.0	Balance
Hardness				
61-65	HRc			
Recommended welding parameters (Ø 2.8 mm)				
	Current (A)	Voltage (V)	Stickout (mm)	
Optimum	450 - 550	30 - 32	30 - 40	
Extendend range	300 - 550	29 - 32	30 - 40	
Packing				
Pack	Drum (Ø 546 mm)			
Weight/pack	250 kg (nominal)			

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.