



CEWELD SA 420B

TYPE Solid stainless steel welding wire for submerged arc welding

APPLICATIONS The best all-purpose steel type for machine element work. Suitable for fairly corrosion resistant overlay welding with a hardness of approx. 50 HRc.

PROPERTIES CEWELD® SA 420B offers fair general corrosion resistance combined with high hardness and excellent wear properties especially to face metal to metal wear problems . Fused flux CEWELD® FL 880 or agglomerated flux CEWELD® FL 838 can be used.

CLASSIFICATION

AWS	A 5.9: ER420
EN ISO	14343-B: S 420
W.Nr.	~1.4028
F-nr	6
FM	5

SUITABLE FOR Shafts, Valves, seats, pistons, Dredging pump casings, continuous casting rollers etc.

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.35	0.4	0.5	0.02	0.02	13	0.4	0.6

MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} (MPa)	R _m (MPa)	A5 (%)	Hardness
As Welded	>250	>450	>15	50 HRc

REDRYING Not required

GAS ACC. EN ISO 14175