



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	 PA  PB														
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