





CEWELD 1.4122

| | | | | | | |
|---|---|---------------------------------------|----------------------|--------|----------|-----|
| TYPE | Solid 17% Cr. welding wire for hardfacing / cladding | | | | | |
| APPLICATIONS | Stainles steel shafts, steam valves, clutch surfaces from trucks, pistons, bearings, fan blades etc. | | | | | |
| PROPERTIES | Solid welding wire that combines high hardness with very good corrosion resistance, shiny weld deposit with a little higher hardness than 1.4115. The weld deposit cannot be machined with normal cutting tools, grinding is possible. Hardness approximately 45 HRc. The deposit can be tempered. | | | | | |
| CLASSIFICATION | AWS | A 5.9: ~ER 430, 636-A: W Z 18 Nb Ti L | | | | |
| | EN ISO | 14343-A: G 13 4 | | | | |
| | W.Nr. | ~ 1.4015 | | | | |
| | F-nr | 5 | | | | |
| | FM | 4 | | | | |
| SUITABLE FOR | 1.4016, 1.4511 X6Cr17, X3CrNb17 UNS S43000 AISI 430 Cast steels, hardfacing pumps, shafts, seats, steam valves etc. Surfacing: unalloyed and low-alloyed steels. | | | | | |
| APPROVALS | CE | | | | | |
| WELDING POSITIONS | <div>PAPBPCPD</div> | | | | | |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | C | Mn | Si | Cr | Ni | Mo |
| | 0.4 | 0.7 | 0.5 | 17 | 0.5 | 1.1 |
| MECHANICAL PROPERTIES | Heat Treatment | R _{P0,2} (MPa) | R _m (MPa) | A5 (%) | Hardness | |
| | As Welded | 550 | 750 | 12 | 45 HRc | |
| REDRYING | Not required | | | | | |
| GAS ACC. EN ISO 14175 | M11, M13, M12 | | | | | |