



CEWELD 1.4122

TYPE	Solid 17% Cr. welding wire for hardfacing / cladding																	
APPLICATIONS	Stainless 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	<p>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</p>																	
SUITABLE FOR	<p>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.</p>																	
APPROVALS	CE																	
WELDING POSITIONS																		
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table><tr><td>C</td><td>Mn</td><td>Si</td><td>Cr</td><td>Ni</td><td>Mo</td></tr><tr><td>0.4</td><td>0.7</td><td>0.5</td><td>17</td><td>0.5</td><td>1.1</td></tr></table>						C	Mn	Si	Cr	Ni	Mo	0.4	0.7	0.5	17	0.5	1.1
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MECHANICAL PROPERTIES	<table><thead><tr><th>Heat Treatment</th><th>R_{P0,2} (MPa)</th><th>Rm (MPa)</th><th>A5 (%)</th><th>Hardness</th></tr></thead><tbody><tr><td>As Welded</td><td>550</td><td>750</td><td>12</td><td>45 HRc</td></tr></tbody></table>						Heat Treatment	R _{P0,2} (MPa)	Rm (MPa)	A5 (%)	Hardness	As Welded	550	750	12	45 HRc		
Heat Treatment	R _{P0,2} (MPa)	Rm (MPa)	A5 (%)	Hardness														
As Welded	550	750	12	45 HRc														
REDRYING	Not required																	
GAS ACC. EN ISO 14175	M11, M13, M12																	