

CEWELD MA 4115

TYPE 17% chrome stainless steel welding wire

APPLICATIONS Hardfacing of shafts from stainless steel parts, repair of moulds, rebuilding of pump parts, thermal spraying, etc. Suitable for plating and joining of ferritic chrome steels and similar and equal cast steels. The welds are subjected to the recommended heat treatment. This welding wire is particularly suitable for sealing surfaces of water, steam and gas valves, especially for sulphurous gases. The deposit is resistant to sea water, fine acids and scale in air and oxidizing gases up to 950°C. The solder deposit can be hardened.

PROPERTIES A stainless steel alloy for the assembly and cladding of 17% chromium alloys and age Hardfacing components where heat and corrosion resistance similar to AISI 304 is required. The weld deposit can withstand working temperatures up to 450°C and offers high hardness and wear resistance.

CLASSIFICATION EN ISO 14700: S Fe7, 14343-A: G 17
W.Nr. 1.4115

SUITABLE FOR 1.4122 (G)X35CrMo17, Cast steels

APPROVALS CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	Cr	Ni	Mo
0.2	0.5	0.6	16.5	0.5	1.1

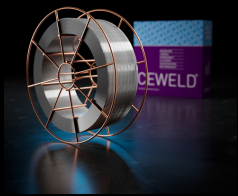
MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded	>300	>450	>20	45 HRC

REDRYING Not required

WELDING INSTRUCTIONS: Because ferritic steels tend to embrittlement due to coarse grain development, the heat input should be as low as possible. For hardfacing on low-alloy base materials, preheating of 150°C- 350°C depending on thickness (on higher strength materials 350°C) should be applied. should be performed. Post-treatment is not necessary, but quenching hardening to the desired hardness can be applied Normally a hardness of 45HRC is achieved in As Welded condition.

GAS ACC. EN ISO 14175 M11, M13, M12



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MA 4115 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663403186