



# CEWELD SA 420C

|                |                                                                                                                                                                                                                                                 |                |  |
|----------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|--|
| TYPE           | Solid stainless steel welding wire for submerged arc welding. (Typ 420C)                                                                                                                                                                        |                |  |
| APPLICATIONS   | he best all-purpose steel type for machine element work. Suitable for fairly corrosion resistant overlay welding with a hardness of approx. 54 HRC.                                                                                             |                |  |
| PROPERTIES     | CEWELD® SA 420C 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.                                                                                                                                                                                                                                           | ~1.4031        |  |
|                | 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  |
|------|-----|-----|------|------|----|-----|-----|
| 0.43 | 0.5 | 0.6 | 0.02 | 0.02 | 13 | 0.4 | 0.6 |

## MECHANICAL PROPERTIES

| Heat Treatment | R <sub>p0.2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Hardness |
|----------------|-------------------------|----------------------|--------------------|----------|
| As Welded      | 250                     | 450                  | 15                 | 54 HRc   |

REDRYING Not required

GAS ACC. EN ISO 14175