



# CEWELD 4122 HL-Kb

|                                             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                               |                      |        |          |
|---------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------|----------------------|--------|----------|
| TYPE                                        | High recovery, corrosion resistant stainless steel stick electrode                                                                                                                                                                                                                                                                                                                                                                                                                           |                               |                      |        |          |
| TOEPASSINGEN                                | Hardfacing shafts from stainless steel parts, molt repairs, rebuilding pump parts etc. Suitable for plating and joining equal and similar ferritic Cr-steels and cast steels. This alloy is specially suitable for sealing surfaces on water-, steam and gas-valves, especially for sulphuric gases.                                                                                                                                                                                         |                               |                      |        |          |
| EIGENSCHAPPEN                               | Proper weldings are subject to the recommended heat treatment. The deposit is resistant to seawater, thin acids and scale resistant in air and oxidizing gases up to 950°C . The weld deposit can be tempered and also can sustain working temperatures up to 450° C. and will offer scale resistance up to much higher temperatures. Preheating is recommended at 150 - 350° C. depending on the thickness of the base metal. Similar base metals should be pre-heated at 300° C to 400° C. |                               |                      |        |          |
| CLASSIFICATIE                               | AWS<br>W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | A 5.4: ~E 430HMo-26<br>1.4122 |                      |        |          |
| GESCHIKT VOOR                               | 1.4016, 1.4511, 1.4122<br>X6Cr17, X3CrNb17, X39CrMo17-1<br>UNS S43000<br>AISI 430<br>Cast steels, hardfacing pumps, shafts, seats, steam valves etc. Surfacing: unalloyed and low-alloyed steels                                                                                                                                                                                                                                                                                             |                               |                      |        |          |
| GOEDKEURINGEN                               |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                               |                      |        |          |
| LASPOSITIES                                 | <div>  </div>                                                                                                                                                                                                                          |                               |                      |        |          |
| TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | Cr                            | Ni                   | Mo     |          |
|                                             | 0.2                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | 14                            | 1                    | 1.2    |          |
| MECHANISCHE WAARDEN                         | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | R <sub>P0,2</sub> (MPa)       | R <sub>m</sub> (MPa) | A5 (%) | Hardness |
|                                             | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | 700                           | 1100                 | 15     | 48 HRc   |
|                                             | 720°C±15°C 2h                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                               |                      |        | 230 HB   |
| HERDROGEN                                   | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                               |                      |        |          |
| GAS ACC. EN ISO 14175                       |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                               |                      |        |          |