

1.4122

CATEGORY GMAW-GTAW Solid wires

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

AWS	A 5.9: ER 430H Mo
EN ISO	14343-A:
DIN: W.Nr.	1.4122
DIN	8556: SG X 35CrMo17

SUITABLE FOR X35CrMo17, Cast steels, hardfacing pumps, shafts, seats, steam valves etc.

WELDING POSITIONS:

WELD METAL WEIGHT %

C	Mn	Si	Cr	Ni	Mo
0.4	0.7	0.5	17	0.5	1.1

ALL WELD METAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				-20°C	-40°C	-60°C	
AW	550	750	12				45

AW: as welded

WELDING PARAMETERS PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet
1,2		180-250	K-300	15	
1,6		250-320	K-300 / Coil	15 / 25	

REDRYING TEMPERATURE Not required

NOTE Tig rods in 1000 mm lenght are available on request.