

## 4122 HL-Kb

**CATEGORY** SMAW Stick Electrodes

**TYPE** High recovery, corrosion resistant stainless steel stick electrode

**APPLICATIONS** 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.

**PROPERTIES** 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.

**CLASSIFICATION**

AWS	A 5.4: ~E 430HMo-26
EN ISO	3581-A: EZ 17 1 R 52
DIN: W.Nr.	1.4122
DIN	8555: E6-UM-50-CP

**SUITABLE FOR** Hardfacing rollers that needs to have corrosion resistance, shafts, valve sealings for water, gas and steam equipment etc.

**WELDING POSITIONS:**



**WELD DEPOSIT WEIGHT % (TYPICAL)**

C	Mn	Si	Cr	Ni	Mo	Fe
0.38	0.35	0.3	16-18	0.3	0.9-1.1	Rem

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A5 (%)	Impact Energy (J) ISO-V			Hardness HRC / HB
				-20°C	-40°C	-60°C	
AW							48 HRC
PWHT 760°C/2hr	600	800	12				230 (HB30)

AW: as welded / PWHT: post weld heat treatment

**WELDING PARAMETERS PACKING**

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A) DC+	kg / can	kg / 6pack	kg / 1000
2.5	350	60-90			
3.2	350	80-110			
4.0	350	100-150			