

MA 4115

CATEGORY GMAW-GTAW Solid wires

TYPE Solid stainless 17% Cromium welding wire

APPLICATIONS Hardfacing shafts from stainless steel parts, molt repairs, rebuilding pump parts, thermal spray etc. Suitable for plating and joining equal and similar ferritic Cr-steels and cast steels. Proper weldings are subject to the recommended heat treatment. This welding wire is specially suitable for sealing surfaces on water-, steam and gas-valves, especially for sulphuric gases. 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.

PROPERTIES Stainless steel alloy for joining and cladding 17% Chromium alloys and cladding components where heat and corrosion resistance similar to AISI 304 is required. The weld deposit can sustain working temperatures up to 450°C and will offer a high hardness and wear resistance.

CLASSIFICATION

AWS	A 5.9:
EN ISO	14343-A: 14343-A: G/W 17
DIN: W.Nr.	1.4115
DIN	8555: E6-200-PR

SUITABLE FOR 1.4122 (G)X35CrMo17, Cast steels

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL WEIGHT %

C	Mn	Si	Cr	Ni	Mo
0,35	0,9	0,4	16-19		

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
				-20°C	-40°C	-60°C	
AW							42-47

AW: as welded / SR: stress relieved

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	Spool type	kg / spool / Coil	kg / pallet
1.0			K-300	15	
1,2			K-300	15	
1.6			K-300	15	
3,2			Coils	25	

REDRYING TEMPERATURE Not required