

SA 420B

CATEGORY SAW Arc Submerged

TYPE Solid stainless steel welding wire for submerged arc welding

APPLICATIONS The best all-purpose steel type for machine element work. Suitable for fairly corrosion resistant overlay welding with a hardness of approx. 50 HRC.

PROPERTIES SA 420B offers fair general corrosion resistance combined with high hardness and excellent wear properties especially to face metal to metal wear problems . Can be used with [Ceweld FL 8111](#).

CLASSIFICATION

AWS	A 5.9: ER 420
EN ISO	14343-B: 2007 420
DIN: W.Nr.	1.4028

SUITABLE FOR Shafts, Valves, seats, pistons, Dredging pump casings, continuous casting rollers etc.

APPROVALS CE approved

WELDING POSITIONS:



WELD DEPOSIT WEIGHT %

C	Mn	Si	Cr	Ni
0.25-0.40	<0.6	<0.50	12.0-14.0	<0.6

MECHANICAL PROPERTIES

Heat Treatment	Rp0,2 MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V			Hardness HRc
				20°C	-40°C	-60°C	
AW							~50

AW: as welded

WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters		spool type	Packing	
	Voltage (V)	Current (A)		kg / spool	kg / pallet
1,6	27-30	200-300	K-415	25	1050
2,4	29-33	300-400	K-415	25	1050
3,2	29-33	350-500	K-415	25	1050
4,0	30-36	400-600	K-415	25	1050

REDRYING TEMPERATURE Not required