

## SP 1.4122

**CATEGORY** Metal spray wires

**TYPE** Solid thermal spray wire containing 17% Chromium

**APPLICATIONS** Stainless steel shafts, valves, clutch surfaces from trucks, pistons, bearings, fan blades etc.

**PROPERTIES** Solid spray wire that combines high toughness with very good corrosion resistance, shiny coating with a little higher hardness than SP 1.4115. The spray deposit cannot be machined with normal cutting tools, grinding is possible. Hardness approximately 50 HRc

**CLASSIFICATION**

AWS	A 5.9:
EN ISO	14343-A:
DIN: W.Nr.	1.4122
DIN	8556: SD X 35CrMo17

**APPROVALS** CE approved

**WELDING POSITIONS:**



**SPRAY WIRE ANALYSIS**

C	Mn	Si	Cr	Ni	Mo	S
0.33-0.43	0.5-1.0	0.30-0.60	15.5-17.5	0.1-1.0	0.9-1.3	< 0.030

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HRc
				-20°C	-40°C	-60°C	
as sprayed							50

Hardness depends on the spray parameters

**WELDING PARAMETERS / PACKING**

D (mm)	Welding Parameters		Packing	
	Voltage (V)	Current (A)	spool type	kg / spool
1.6			K-300 / D-300	15
3.17			K-415 / H-420	25
4.76			Coils	25

**REDRYING TEMPERATURE** not required