

SP 1.4370

CATEGORY Metal spray wires

TYPE High Manganese alloyed stainless steel wire. Excellent wearing qualities and good corrosion resistance

APPLICATIONS Recommended for applications where high corrosion resistance and relatively low wear protection are required.SP 1.4370 is good for general machine element work including hydraulic rams, rolls and for applications in the food industry.

PROPERTIES Coatings of SP 1.4370 exhibit low shrink and are recommend for internal diameters, particularly where thick coatings are needed. Using the combustion wire spray process, SP 1.4370 coatings can be sprayed thicker than SP 1.4316 coatings, but not as thick as SP 420 coatings.

CLASSIFICATION

AWS	A 5.9: ER 307 (mod.)
EN ISO	14343-A: G 18 8 MnSi 14343-B: SSZ307
DIN: W.Nr.	1.4370
DIN	8556: SG X15CrNiMn 18 8

SUITABLE FOR Metals spray wire with good corrosion resistance and low schrink factor, recomended for inside diameters.

APPROVALS CE approved

WELDING POSITIONS:



C	Mn	Si	Cr	Ni	P	S
<0.12	6.5	0.6-1.0	18.5	8.5	<0.025	<0.025

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HB
				-20°C	-40°C	-60°C	
							210-400

SPRAY PARAMETERS / PACKING

Process Parameters			Packing	
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool
1.6	27-29	100-280	S-300	15
2.4	29-32	150-280	K-415 / H-420 / Coils	25
3.2	29-32	150-380	K-415 / H-420 / Coils	25
4.76	29-34	250-450	K-415 / H-420 / Coils	25

REDRYING TEMPERATURE not required