

SP 420-B

CATEGORY Metal spray wires

TYPE High chromium stainless steel wire. Excellent wearing qualities and fair corrosion resistance.

APPLICATIONS The best all-purpose steel for machine element work. Metal spray wire for fairly corrosion resistant coatings with a hardness of approx. 50 HRc.

PROPERTIES Ceweld SP 420B can be applied with the flame spray process and the electric arc process as well and offer extremely stable arc properties. The chemical cleaned surface assures excellent feeding properties.

CLASSIFICATION

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

SUITABLE FOR Shafts, Valves, seats, pistons etc.

APPROVALS CE approved

WELDING POSITIONS:



WIRE ANALYSIS %

C	Mn	S	P	Si	Cr	Ni
0.25-0.40	< 0.6	< 0.030	< 0.030	< 0.50	12.0-14.0	< 0.6

MECHANICAL PROPERTIES

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

Hardness depends on process parameters.

SPRAY PARAMETERS / PACKING

Process Parameters			Packing	
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool
1.6	27-29	100-280	K-300 / D-300	15
3.17 / 3.2	29-32	150-380	K-415 / H-420	25
4.76	29-34	250-450	Coils	25

REDRYING TEMPERATURE not required