



CEWELD 1.4122

TYPE	Solid 17% Cr. welding wire for hardfacing / cladding					
APPLICATIONS	Stainles steel shafts, steam valves, clutch surfaces from trucks, pistons, bearings, fan blades etc.					
PROPERTIES	Solid welding wire that combines high hardness with very good corrosion resistance, shiny weld deposit with a little higher hardness than 1.4115. The weld deposit cannot be machined with normal cutting tools, grinding is possible. Hardness approximately 45 HRc. The deposit can be tempered.					
CLASSIFICATION	AWS	A 5.9: ~ER 430, 636-A: W Z 18 Nb Ti L				
	EN ISO	14343-A: G 13 4				
	W.Nr.	~ 1.4015				
	F-nr	5				
	FM	4				
SUITABLE FOR	1.4016, 1.4511 X6Cr17, X3CrNb17 UNS S43000 AISI 430 Cast steels, hardfacing pumps, shafts, seats, steam valves etc. Surfacing: unalloyed and low-alloyed steels.					
APPROVALS	CE					
WELDING POSITIONS	 PA  PB  PC  PD					
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Mn	Si	Cr	Ni	Mo
	0.4	0.7	0.5	17	0.5	1.1
MECHANICAL PROPERTIES	Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A5 (%)	Hardness	
	As Welded	550	750	12	45 HRc	
REDRYING	Not required					
GAS ACC. EN ISO 14175	M11, M13, M12					