



# CEWELD MA 4115 Tig

TYPE	Solid stainless 17% Chromium welding wire												
APPLICATIONS	Hardfacing shafts from stainless steel parts, molt repairs, rebuilding pump parts, thermal spray etc. Suitable for plating and joining equal and similar ferritic Cr-steels and cast steels. Proper weldings are subject to the recommended heat treatment. This welding wire is specially suitable for sealing surfaces on water-, steam and gas-valves, especially for sulphuric gases. The deposit is resistant to seawater, thin acids and scale resistant in air and oxidizing gases up to 950°C. The weld deposit can be tempered.												
PROPERTIES	Stainless steel alloy for joining and cladding 17% Chromium alloys and cladding components where heat and corrosion resistance similar to AISI 304 is required. The weld deposit can sustain working temperatures up to 450°C and will offer a high hardness and wear resistance.												
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.9: ER430</td> </tr> <tr> <td>EN ISO</td> <td>14343-A: W 17</td> </tr> <tr> <td>DIN</td> <td>8555: TIG 6-GZ-200-PR</td> </tr> <tr> <td>FM</td> <td>5</td> </tr> <tr> <td>W.Nr.</td> <td>1.4115</td> </tr> </table>	AWS	A 5.9: ER430	EN ISO	14343-A: W 17	DIN	8555: TIG 6-GZ-200-PR	FM	5	W.Nr.	1.4115		
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DIN	8555: TIG 6-GZ-200-PR												
FM	5												
W.Nr.	1.4115												
SUITABLE FOR	1.4122 (G)X35CrMo17, Cast steels												
APPROVALS	No Approvals Found												
WELDING POSITIONS													
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> </tr> </thead> <tbody> <tr> <td>0.1</td> <td>0.5</td> <td>0.6</td> <td>16.5</td> <td>0.5</td> <td>0.5</td> </tr> </tbody> </table>	C	Si	Mn	Cr	Ni	Mo	0.1	0.5	0.6	16.5	0.5	0.5
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ALL WELD MECHANICAL PROPERTIES	<table border="1"> <thead> <tr> <th>Heat Treatment</th> <th>R<sub>P0,2</sub> MPa</th> <th>R<sub>m</sub> MPa</th> <th>A<sub>5</sub> (%)</th> <th>Hardness Rockwell C</th> </tr> </thead> <tbody> <tr> <td>As Welded /</td> <td></td> <td></td> <td></td> <td>Avg. 45</td> </tr> </tbody> </table>	Heat Treatment	R <sub>P0,2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)	Hardness Rockwell C	As Welded /				Avg. 45		
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REDRYING TEMPERATURE	Not required												
GAS ACCORDING EN 14175	I1												



# CEWELD MA 4115 Tig

MA 4115 TIG 1,6 X 1000MM	Type	KG/unit	EANCode
	Tube	5	8720663403261
MA 4115 TIG 2,0 X 1000MM	Type	KG/unit	EANCode
	Tube	5	8720663403278
MA 4115 TIG 3,0 X 1000MM	Type	KG/unit	EANCode
	Tube	5	8720663403285