



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				
	AWS	14343-A: W Z 18 Nb Ti L				
	EN ISO	14343-A: G 13 4				
	F-nr	5				
	FM	4				
	W.Nr.	~ 1.4015				
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						
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Mn	Si	Cr	Ni	Mo
	0.4	0.7	0.5	17	0.5	1.1
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} MPa	R _m MPa	A5 (%)	Hardness Rockwell C	
	As Welded /	550	750	12	Avg. 45	
REDRYING TEMPERATURE	Not required					
GAS ACCORDING EN 14175	M11, M13, M12					