





Mο

1.1

0.5

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

Mn

EN ISO 14343-A: G 13 4

F-nr 5 FM 4

W.Nr. ~ 1.4015

SUITABLE FOR 1.4016, 1.4511

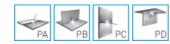
X6Cr17, X3CrNb17 UNS S43000 AISI 430

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 (%)

ALL WELD MECHANICAL

PROPERTIES

Heat	R _{P0,2}	Rm	A5	Hardness
Treatment	MPa	MPa	(%)	Rockwell C
As Welded /	550	750	12	Avg. 45

0.5

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175 M11, M13, M12