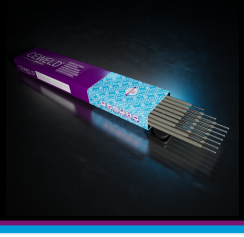

CEWELD 4122 HL-Kb

certilas® THE FILLER METAL SPECIALIST

TYPE

High recovery, corrosion resistant stainless steel stick electrode

APPLICATIONS

Hardfacing shafts from stainless steel parts, molt repairs, rebuilding pump parts etc. Suitable for plating and joining equal and similar ferritic Cr-steels and cast steels. This alloy is specially suitable for sealing surfaces on water-, steam and gas-valves, especially for sulphuric gases.

PROPERTIES

Proper weldings are subject to the recommended heat treatment. 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 and also can sustain working temperatures up to 450° C. and will offer scale resistance up to much higher temperatures. Preheating is recommended at 150 - 350° C. depending on the thickness of the base metal. Similar base metals should be pre-heated at 300° C to 400° C.

CLASSIFICATION

AWS	A 5.4: ~E 430HMo-26
W.Nr.	1.4122

SUITABLE FOR

1.4016, 1.4511, 1.4122
X6Cr17, X3CrNb17, X39CrMo17-1
UNS S43000
AISI 430
Cast steels, hardfacing pumps, shafts, seats, steam valves etc. Surfacing: unalloyed and low-alloyed steels

APPROVALS

No Approvals Found

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Cr	Ni	Mo
0.2	14	1	1.2

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Hardness Brinell Hardness
As Welded / 720°C±15°C /2h	700	1100	15	Avg. 48 Avg. 230

REDRYING TEMPERATURE

Not required

GAS ACCORDING EN 14175