



# 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<br>X6Cr17, X3CrNb17<br>UNS S43000<br>AISI 430<br>Cast steels, hardfacing pumps, shafts, seats, steam valves etc. Surfacing: unalloyed and low-alloyed steels.                                                                                                                                                                           |                                       |                      |        |          |     |
| APPROVALS                                         | CE                                                                                                                                                                                                                                                                                                                                                     |                                       |                      |        |          |     |
| WELDING POSITIONS                                 | <div>   </div> |                                       |                      |        |          |     |
| 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 <sub>P0,2</sub> (MPa)               | R <sub>m</sub> (MPa) | A5 (%) | Hardness |     |
|                                                   | As Welded                                                                                                                                                                                                                                                                                                                                              | 550                                   | 750                  | 12     | 45 HRc   |     |
| REDRYING                                          | Not required                                                                                                                                                                                                                                                                                                                                           |                                       |                      |        |          |     |
| GAS ACC. EN ISO 14175                             | M11, M13, M12                                                                                                                                                                                                                                                                                                                                          |                                       |                      |        |          |     |