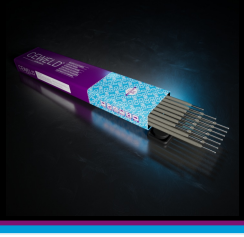

CEWELD 4122 HL-Kb

certilas® THE FILLER METAL SPECIALIST

TYPE	High recovery, corrosion resistant stainless steel stick electrode
TOEPASSINGEN	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.
EIGENSCHAPPEN	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.
CLASSIFICATIE	AWS A 5.4: ~E 430HMo-26 W.Nr. 1.4122
GESCHIKT VOOR	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
GOEDKEURINGEN	
LASPOSITIES	

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Cr	Ni	Mo
0.2	14	1	1.2

MECHANISCHE WAARDEN

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

HERDROGEN	Not required
GAS ACC. EN ISO 14175	