



CEWELD 4122 HL-Kb

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 W.Nr.	A 5.4: ~E 430HMo-26 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					
WELDING POSITIONS	  				
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Cr	Ni	Mo	
	0.2	14	1	1.2	
MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Hardness
	As Welded	700	1100	15	48 HRc
	720°C±15°C 2h				230 HB
REDRYING	Not required				
GAS ACC. EN ISO 14175					