

SP 1.4122

CATEGORY Metal spray wires

TYPE Solid thermal spray wire containing 17% Chromium

APPLICATIONS Stainless steel shafts, valves, clutch surfaces from trucks, pistons, bearings, fan blades etc.

PROPERTIES Solid spray wire that combines high toughness with very good corrosion resistance, shiny coating with a little higher hardness than SP 1.4115. The spray deposit cannot be machined with normal cutting tools, grinding is possible. Hardness approximately 50 HRc

CLASSIFICATION

AWS	A 5.9:
EN ISO	14343-A:
DIN: W.Nr.	1.4122
DIN	8556: SD X 35CrMo17

APPROVALS CE approved

WELDING POSITIONS:



SPRAY WIRE ANALYSIS

C	Mn	Si	Cr	Ni	Mo	S
0.33-0.43	0.5-1.0	0.30-0.60	15.5-17.5	0.1-1.0	0.9-1.3	< 0.030

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc
				-20°C	-40°C	-60°C	
as sprayed							50

Hardness depends on the spray parameters

WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters		Packing	
	Voltage (V)	Current (A)	spool type	kg / spool
1.6			K-300 / D-300	15
3.17			K-415 / H-420	25
4.76			Coils	25

REDRYING TEMPERATURE not required