

SP 420-B

CATEGORY	Metal spray wires
TYPE	High chromium stainless steel wire. Excellent wearing qualities and fair corrosion resistance.
APPLICATIONS	The best all-purpose steel for machine element work. Metal spray wire for fairly corrosion resistant coatings with a hardness of approx. 50 HRc.
PROPERTIES	Ceweld SP 420B can be applied with the flame spray process and the electric arc process as well and offer extremely stable arc properties. The chemical cleaned surface assures excellent feeding properties.
CLASSIFICATION	AWS A 5.9: ER 420 EN ISO 14343-B: 2007 420 DIN: W.Nr. 1.4028
SUITABLE FOR	Shafts, Valves, seats, pistons etc.
APPROVALS	CE approved

WELDING POSITIONS:



WIRE ANALYSIS %

C	Mn	S	P	Si	Cr	Ni
0.25-0.40	< 0.6	< 0.030	< 0.030	< 0.50	12.0-14.0	< 0.6

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	
							50

Hardness depends on process parameters.

SPRAY PARAMETERS / PACKING

Process Parameters			Packing	
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool
1.6	27-29	100-280	K-300 / D-300	15
3.17 / 3.2	29-32	150-380	K-415 / H-420	25
4.76	29-34	250-450	Coils	25

REDRYING TEMPERATURE not required