

CATEGORY	Metal spray wires	
TYPE	Stainless steel alloy exceeding AISI 304 for corrosion protection layers.	
APPLICATIONS	Recommended for applications where corrosion resistance and relatively low wear protection is required. CEWELD® SP 1.4302 is good for general machine element work including hydraulic rams, rolls and for applications in the food industry.	
PROPERTIES	Coatings of CEWELD® SP 1.4302 exhibit good corrosion resistance against organic and non-oxidizing liquids and are recommend for internal and external diameters. Using the combustion wire spray process, CEWELD® SP 1.4302 should be sprayed thinner than CEWELD® SP 1.4370 and CEWELD® SP 420 coatings.	
CLASSIFICATION	EN ISO W.Nr.	14919: 5.10 1.4302
SUITABLE FOR	Corrosion protection in food environments, paper rollers etc.	
APPROVALS	No Approvals Found	

WELDING POSITIONS:



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	Cr	Ni
0.02	1	1	19	9.5

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	Hardness Brinell Hardness
As Welded /1h				Avg. 210

WELDING PARAMETERS / PACKING

PROCESS PARAMETERS	PROCESS PARAMETERS	PROCESS PARAMETERS	PACKING	PACKING
D (MM)	VOLTAGE (V)	CURRENT (A)	SPOOL TYPE	KG / SPOOL
1.6	27-29	100-280	S-300	15
2.4	29-32	150-280	K-415 / H-420 / COILS	25
3.2	29-32	150-380	K-415 / H-420 / COILS	25
4.76	29-34	250-450	K-415 / H-420 / COILS	25

REDRYING TEMPERATURE	Not required
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GAS ACCORDING EN 14175