CEWELD® MA 4115

CATEGORY	GMAW Solid wires
TYPE	17% chrome stainless steel welding wire
APPLICATIONS	Hardfacing of shafts from stainless steel parts, repair of moulds, rebuilding of pump parts, thermal spraying, etc. Suitable for plating and joining of ferritic chrome steels and similar and equal cast steels. The welds are subjected to the recommended heat treatment. This welding wire is particularly suitable for sealing surfaces of water, steam and gas valves, especially for sulphourus gases. The deposit is resistant to sea water, fine acids and scale in air and oxidizing gases up to 950°C. The solder deposit can be hardened.
PROPERTIES	A stainless steel alloy for the assembly and cladding of 17% chromium alloys and age Hardfacing components where heat and corrosion resistance similar to AISI 304 is required. The weld deposit can withstand working temperatures up to 450°C and offers high hardness and wear resistance.

CLASSIFICATION

AWS	A 5.9: ER430
EN ISO	14343-A: G 17
DIN	8555: E6-200-PR
F-nr	6
FM	5
W.Nr.	1.4115

SUITABLE FOR	1.4122 (G)X35CrMo17, Cast steels
APPROVALS	No Approvals Found

WELDING POSITIONS:

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	Cr	Mo
0.2	0.5	0.6	16.5	0.5

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)		Hardness Rockwell C
As Welded /					Avg. 45

WELDING PARAMETERS / PACKING

WELDING PARAMETERS	WELDING PARAMETERS	WELDING PARAMETERS	PACKING	PACKING	PACKING
D (MM)	VOLTAGE (V)	CURRENT (A)	SPOOL TYPE	KG / SPOOL / COIL	KG / PALLET
1.0			K-300	15	
1,2			K-300	15	
1.6			K-300	15	
3,2			COILS	25	

REDRYING TEMPERATURE	Not required
GAS ACCORDING EN 14175	M11, M13, M12