

CATEGORY GTAW Solid wires

TYPE Solid stainless 17% Cromium welding wire

APPLICATIONS Hardfacing shafts from stainless steel parts, molt repairs, rebuilding pump parts, thermal spray etc. Suitable for plating and joining equal and similar ferritic Cr-steels and cast steels. Proper weldings are subject to the recommended heat treatment. This welding wire is specially suitable for sealing surfaces on water-, steamand gas-valves, especially for sulphuric gases. 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.

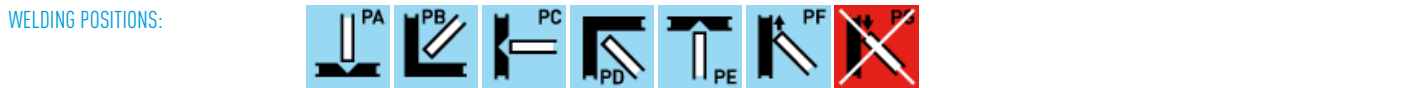
PROPERTIES Stainless steel alloy for joining and cladding 17% Chromium alloys and cladding components where heat and corrosion resistance simimilar to AISI 304 is required. The weld deposit can sustain working temperatures up to 450°C and will offer a high hardness and wear resistance.

CLASSIFICATION

AWS	A 5.9: ER430
EN ISO	14343-A: W 17
DIN	8555: TIG 6-GZ-200-PR
FM	5
W.Nr.	1.4115

SUITABLE FOR 1.4122 (G)X35CrMo17, Cast steels

APPROVALS No Approvals Found



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	Cr	Mo
0.1	0.5	0.6	16.5	0.5

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness (Rockwell C)
As Welded /				Avg. 45

WELDING PARAMETERS / PACKING

WELDING PARAMETERS	WELDING PARAMETERS	WELDING PARAMETERS	PACKING	PACKING
D (MM)	LENGTH (MM)	CURRENT (A)	KG	KG / PACK
2.0	1000		5	25
2.4	1000		5	25

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175 I1