

CATEGORY	SAW Arc Submerged	
TYPE	Solid stainless steel welding wire for submerged arc welding	
APPLICATIONS	The best all-purpose steel type for machine element work. Suitable for fairly corrosion resistant overlay welding with a hardness of approx. 50 HRc.	
PROPERTIES	CEWELD® SA 420B offers fair general corrosion resistance combined with high hardness and excellent wear properties especially to face metal to metal wear problems . Fused flux CEWELD® FL 880 or agglomerated flux CEWELD® FL 838 can be used.	
CLASSIFICATION	AWS EN ISO F-nr FM W.Nr.	A 5.9: ER420 14343-B: S 420 6 5 -1.4028
SUITABLE FOR	Shafts, Valves, seats, pistons, Dredging pump casings, continuous casting rollers etc.	

APPROVALS No Approvals Found

WELDING POSITIONS:



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.35	0.4	0.5	0.02	0.02	13	0.4	0.6

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R <sub>p0.2</sub> MPa	R <sub>m</sub> MPa	A5 (%)	Hardness Rockwell C
As Welded /				Avg. 50

WELDING PARAMETERS / PACKING

WELDING PARAMETERS	WELDING PARAMETERS	WELDING PARAMETERS	PACKING	PACKING	PACKING
D (MM)	VOLTAGE (V)	CURRENT (A)	SPOOL TYPE	KG / SPOOL	KG / PALLET
1,6	27-30	200-300	K-415	25	1050
2,4	29-33	300-400	K-415	25	1050
3,2	29-33	350-500	K-415	25	1050
4,0	30-36	400-600	K-415	25	1050

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175