
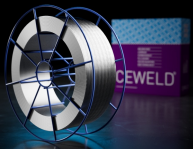




CEWELD SP 420-B

TYPE	High carbon 13% chromium stainless steel wire for metal spray										
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 420-B 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	EN ISO 14919: X.mod type W.Nr. 1.4028										
SUITABLE FOR	Shafts, Valves, seats, pistons etc.										
APPROVALS											
WELDING POSITIONS											
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th style="width: 20%;">Si</th> <th style="width: 20%;">Mn</th> <th style="width: 20%;">Cr</th> <th style="width: 20%;">C</th> <th style="width: 20%;">Ni</th> </tr> </thead> <tbody> <tr> <td>0.2</td> <td>0.2</td> <td>13</td> <td>0.35</td> <td>0.4</td> </tr> </tbody> </table>	Si	Mn	Cr	C	Ni	0.2	0.2	13	0.35	0.4
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MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th style="width: 25%;">Heat Treatment</th> <th style="width: 25%;">R_{P0,2} (MPa)</th> <th style="width: 25%;">R_m (MPa)</th> <th style="width: 25%;">A₅ (%)</th> <th style="width: 25%;">Hardness</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td></td> <td></td> <td></td> <td>50 HRc</td> </tr> </tbody> </table>	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness	As Welded				50 HRc
Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness							
As Welded				50 HRc							
REDRYING	Not required										
GAS ACC. EN ISO 14175	M21										



CEWELD SP 420-B

SP 420-B 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663409744

SP 420-B 2,0MM

Packaging	KG/unit	EanCode
K-415	15	8720663409799