



# CEWELD 4122 HL-Kb

**TYPE** High recovery, corrosion resistant stainless steel stick electrode

**TOEPASSINGEN** Hardfacing shafts from stainless steel parts, molt repairs, rebuilding pump parts etc. Suitable for plating and joining equal and similar ferritic Cr-steels and cast steels. This alloy is specially suitable for sealing surfaces on water-, steam and gas-valves, especially for sulphuric gases.

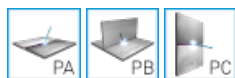
**EIGENSCHAPPEN** Proper weldings are subject to the recommended heat treatment. The deposit is resistant to seawater, thin acids and scale resistant in air and oxidizing gases up to 950°C . The weld deposit can be tempered and also can sustain working temperatures up to 450° C. and will offer scale resistance up to much higher temperatures. Preheating is recommended at 150 - 350° C. depending on the thickness of the base metal. Similar base metals should be pre-heated at 300° C to 400° C.

**CLASSIFICATIE** AWS A 5.4: ~E 430HMo-26  
W.Nr. 1.4122

**GESCHIKT VOOR** 1.4016, 1.4511, 1.4122  
X6Cr17, X3CrNb17, X39CrMo17-1  
UNS S43000  
AISI 430  
Cast steels, hardfacing pumps, shafts, seats, steam valves etc. Surfacing: unalloyed and low-alloyed steels

**GOEDKEURINGEN**

**LASPOSITIES**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

| C   | Cr | Ni | Mo  |
|-----|----|----|-----|
| 0.2 | 14 | 1  | 1.2 |

**MECHANISCHE WAARDEN**

| Heat Treatment | R <sub>P0.2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Hardness |
|----------------|-------------------------|----------------------|--------------------|----------|
| As Welded      | 700                     | 1100                 | 15                 | 48 HRc   |
| 720°C±15°C 2h  |                         |                      |                    | 230 HB   |

**HERDROGEN** Not required

**GAS ACC. EN ISO 14175**