



# CEWELD 4122 HL-Kb

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

**APPLICATIONS** 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.

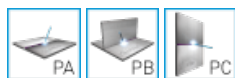
**PROPERTIES** Proper weldings are subject to the recommended heat treatment. The deposit is resistant to seawater, thin acids and scale resistant in air and oxidizing gases up to 950°C . The weld deposit can be tempered and also can sustain working temperatures up to 450° C. and will offer scale resistance 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.

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

**SUITABLE FOR** 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

**APPROVALS**

**WELDING POSITIONS**



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

C	Cr	Ni	Mo
0.2	14	1	1.2

**MECHANICAL PROPERTIES**

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

**REDRYING** Not required

**GAS ACC. EN ISO 14175**