

Meltolit

420 XM

AWS A 5.9: ER420 EN ISO 14343-B: 420
W.N: 1.4031

DESCRIPTION

Corrosion and heat resistant martensitic stainless steel similar to 410, but with slightly higher chromium and carbon. Hardenable by heat treatment. Used for many surfacing operations requiring superior resistance to abrasion, as well as corrosion resistance along with somewhat higher hardness than weld metals deposited by 410 electrodes, which increases wear resistance. It requires preheat and inter-pass temperatures of >200°C, followed by slow cooling. Post weld heat treatment is used to temper the weld deposit.

WELDING POSITIONS



CURRENT

DC+

GAS

Ar/Co2(M12)

BASE MATERIAL

410, 420

MECHANICAL PROPERTIES

<i>R_m</i> (Mpa)	<i>R_{p 0,2}</i> (Mpa)	<i>A5</i> (%)	<i>KV(j)</i>	
>450	>250	>15		

CHEMICAL ANALYSIS(%)

C	Mn	Si	Cr	Mo	Ni	Cu
0,4	0,6	0,5	14	0,75	0,6	0,75

PACKAGING

Dimension(mm)	0,8	1,0	1,2	
Spole(kg)	15	15	15	

EQUIVALENT FILLER METALS

MMA	Meltolit 420 E
TIG	Meltolit 420 XT