

CARBO S- 1.4122 CARBO T- 1.4122

International standards				S = solid wire						T = bare rod				
		Mat. No	Э.		1.41									
		EN 120	GΖ	G Z 17 Mo H				17 Mo H						
		DIN 85	56	SG	-X35 C	CrMo 17	7							
Approvals														
Application notes		CARBO S-1.4122 is solid wire electrode for plating and joining equal and similar ferritic Cr-steels and cast steels. Proper weldings are subject to the recommended heat treatment. The electrode is specially suitable for sealing surfaces on water-, steam- and gas-valves. The deposits can be tempered.												
Operating temperat	ure	Room temperature up to 450° C												
Base materials		1.4122 (G)X35CrMo17												
Recommendations fabrication	for	Since ferritic steels tend to embrittlement caused by coarse grain development the heat input should be as low as possible. For hardfacing on low alloyed base materials a preheating of 150 [^] C- 350°C subject to the thickness (on materials with higher strength 350°C) should be done. Post weld treatment is not necessary but quench hardening to the desired hardness may be applied												
Mechanical properties of all-weld metal (typical values)		Tensile strength R _m N/mm²			Yield strength R _{p0,2} N/mm ²					Elongation A ₅ %		on	Hardness HRc	
		550			750						12		ca45	
Weld metal analysis (typical, wt. %)	•	C 0,4	Si 0,5	М і 0,8		Cr 6,5	M 1,		Ni 0,5					
		wire					T = bare rod							
Gas types EN 439		M 12 / M 13									11			
Current Diameter n Welding amps (A) n (A) n		0,8 80 130	1,0 120 190	= +	1,2 180 250	1,6 250 320		1,6	2,	0	= – 2,4	3,2	4,0	
coils, weight Rev. 001/13		B300 15 kg.				10 kg.								

Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. Carbo-Weld may change the characteristics of its products without notice. We recommend the applier to check our products for their special application autonomously.