



DAIKOWS 420C



FERRITIC - MARTENSITIC STAINLESS
STEEL
420

DESCRIPTION

Martensitic harfacing wire rod for 13%Cr stainless steels

This wire rod deposits a weld metal similar to 420B with higher carbon content and is used for surfacing operation requiring corrosion resistance and wear resistance on matching base materials and also on CMn steels. The higher carbon content results in higher hardness but lower toughness. Application include welding of similar parental metal, weld overlay and thermal spraying. Suitable for cladding of continuous casting rolls.

SPECIFICATIONS

ISO 14343-B	SS420	AWS A5.9	ER420
DIN	-	Werkstoff Number	-
Certifications	-	Shielding	DAIKOFLUX 493-W
Positions	PA, PB, PC	Current	DC/AC

ASME QUALIFICATIONS

F-No (QW432)	6	FERRITE	-	PREN	13	HARDNESS	40HRC - 50HRC PWHT
A-No (QW442)	6						

CHEM. COMP. %

CHEM. COMP. %	DEFAULT
C	0.4
Mn	0.6
Ni	0.5
Cr	13
P	0.03
S	0.03
Si	0.5
Cu	0.3

MECHANICAL PROPERTIES

	MIN	VARIANT
Tensile strength R_m MPa	450	750
Yield strength $R_{p0.2}$ MPa	250	500
Elongation A ($L_0=5d_0$) %	15	30
Impact Charpy ISO-V	-	50J @ 20°C
Impact Charpy ISO-V	-	-

WELDING PARAMETERS

	2.4 mm
Ampere	250A - 420A
Voltage	28V - 32V
Packaging	Ø 2,0÷4,0mm
Packaging Type	K415 spool and drums.

ANTI-WEAR CHARACTERISTICS

Adhesive wear	▲ ▲ ▲ ▲ ▲
Abrasive wear	▲ ▲ ▲ ▲ ▲
Impact	▲ ▲ ▲ ▲ ▲
Corrosion	▲ ▲ ▲ ▲ ▲
Heat	▲ ▲ ▲ ▲ ▲

V 01/2024



The information in this datasheet is the result of detailed research and is considered accurate as of the publication date. However, we cannot guarantee its complete accuracy, and it is subject to change without notice. Actual results may vary due to many factors like welding procedures, material composition, temperature conditions, bevel configuration, and specific manufacturing techniques. We accept no liability for any errors or omissions in this datasheet. For the most current information, please visit www.daikowelding.com.





420

DESCRIPTION

FERRITIC - MARTENSITIC STAINLESS
STEEL
420

APPLICATION

Sharing similarities with ER410, this alloy distinguishes itself through a slight increase in both chromium and carbon contents. Its utilization extends to a myriad of surfacing operations where a combination of corrosion resistance (attributed to its 12 percent chromium composition) and augmented hardness for heightened wear resistance is paramount. This alloy finds its primary application in surfacing the sealing faces of valves employed in gas, water, and steam piping systems, especially under service temperatures reaching up to +450 °C. Beyond this, its versatility encompasses various applications, including welding similar parental metal, weld overlay, thermal spraying, and the cladding of continuous casting rolls. Remarkably, if the envisaged application demands the use of parts in the "as-welded" condition, achieving a ductile joint is entirely feasible. This is achieved through the application of austenitic fillers, with options such as 22 12 L/309, 18 8 Mn/307, or 25 20/310 proving suitable for this purpose.

ALLOY TYPE

Ferritic martensitic stainless steels.

MICROSTRUCTURE

The microstructure comprises tempered martensite and some carbide.

MATERIALS

Corrosion resistant Cr-steels as well as other similar-alloyed steels with C-contents ≤ 0.30 % (repair welding), heat resistant Cr-steels of similar chemical composition.

EN W.Nr.: 1.4006 (X12Cr13), 1.4021 (X20Cr13), +

ASTM: 410, 420.

WELDING & PWHT

Implementing pre-heating and meticulous interpass temperature control during welding, coupled with a deliberate and gradual cooling process followed by Post Weld Heat Treatment (PWHT), serves as effective preventive measures against cracking. For joint welding, a recommended preheating temperature of +200 - 300 °C is advisable, the specific value depending on the alloy type and strength levels. Correspondingly, the interpass temperature should be maintained within the same range. Ensuring an optimal heat input is crucial, avoiding extremes with a recommended range of 0.5 - 1.5 kJ/mm. The hardness of the deposit is contingent upon the degree of dilution with the base metal and its chemical composition. Generally observed is the correlation where higher degrees of dilution and higher C-content in the base metal result in increased deposit hardness. Post-weld heat treatment becomes a requisite to reinstate ductility to the weld zone. This involves tempering at temperatures ranging from +700 - 750 °C, a process aimed at enhancing the toughness of the welded structure. This comprehensive approach guarantees the mechanical integrity and performance of the welded joints.

