

KM-420

Classification

Shielding Gas: Ar+1~2%O₂
Ar+1~2%CO₂

AWS A5.9/A5.9M ER420

Applications and Features

- (1) Weld metal is martensitic structure with 13%Cr.
- (2) Weld metal has higher hardness vs 410 grade due to higher carbon content.
- (3) It is suitable for build-up of corrosion resistant components

Welding Instruction

- (1) Use Ar blend with 1~2%O₂ for high current, spray transfer welding .
- (2) Use Ar blend with 1~2%CO₂ for low current, short-circuit transfer welding.

Typical Chemical Composition of Wire (wt%)

C	Si	Mn	P	S	Cr
0.312	0.42	0.52	0.014	0.012	13.25

Typical Mechanical Properties of Weld Metal (Shielding Gas : Ar+2% O₂)

Tensile Strength MPa	HRC
—	50

Size and Suggested Operating Range (DC+)

Shielding Gas		Diameter (mm)	
		1.2	1.6
Ar+1~2%CO ₂	Amp	100~210	—
	Volt	17~22	—
Ar+1~2%O ₂	Amp	200~300	220~330
	Volt	24~30	24~32

Diam.	15 kg Spool
1.6mm	KM4201615

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