



Stainless Steel Solid Wire

TIG Welding

AWS A5.9: ER420
ISO 14343-B-2009 420

SW-420

DESCRIPTION & APPLICATION

TIG Filler wire for the joining and overlay of Stainless Steels of similar composition (Straight Chrome) Martensitic deposit, which is hardenable. Higher carbon version of 410.

BASE MATERIALS

AISI 420
ASTM A743 Gr CA15

MECHANICAL PROPERTIES

~650n/mm	~450	-	300*
UTS n/mm	YIELD 0.2%	ELONG A5%	HARDNESS HV

*As per heat treatment

METAL WELD COMPOSITION %

C	Si	Mn	Cr	Ni	Mo	S	P	Fe
0.4	0.35	0.5	13.0	0.3	0.1	0.02	0.025	BAL

PACKAGING

15kg Spools (MIG)
5kg Tubes (TIG)

DIAMETERS

0.8, 1, 1.2mm (MIG)
1.6, 2.4, 3.2mm (TIG)

WELDING INSTRUCTIONS

Shielding gas TIG 100% Argon. Preheat to 200-300°C depending on component thickness and geometry, maintain interpass temperature above 150°C Slow cool in vermiculite or similar. Post Weld Heat Treat as per Hardness/Temper requirements.

Need Help?

01925 839983

sales@westbrookwelding.co.uk

Discover all our specification sheets to help you more:
westbrookwelding.co.uk **downloads**