

RAAJER 420

Ferrite steel cut length solid welding wire for Specially TIG welding

CLASSIFICATION : AWS/SFA-5.9: ER420, BS 13H
DIN 8556: WK. 1.4007

CHARACTERISTICS : ER420 is Ferrite steel welding wire for used in specially TIG for many surfacing operations there are requiring corrosion resistance by 12%Cr.

APPLICATION : this grade generally suitable for TIG welding process of their equivalent 12 to 14 %chromium base materials,

SHIELDING GAS : welding with 100% Ar gas Or Ar+CO₂ (80/20) gas.

CHEMICAL COMPOSITION % (solid wire chemistry)

C	Mn	Si	S	P	Ni
0.25-0.40	0.60 Max.	0.50 Max.	0.030 Max	0.030 Max	0.60 Max.
Cr	Mo	Cu			
12.50-14.00	0.75 max.	0.75 Max			

DIEMENSION, CURRENT CONDITION & PACKING DATA (RAAJER420)

Size(mm)	Size(inch)	Length (mm)	Length (inch)	Current Condition (DC+)	Voltage (V)	Tube packing 5 kg	Box packing 20 kg
1.60	1/ 16"	1000	36"	40-80	10-16	√	√
2.0	5/ 64"	1000	36"	50-100	12-18	√	√
2.4/ 2.5	3/ 32"	1000	36"	60-120	14-20	√	√
3.2	1/ 8"	1000	36"	100-150	16-24	√	√
4.0	5/ 32"	1000	36"	140-200	18-28	√	√

Raajratna offer a wide range of Stainless steel welding wires for MIG/TIG/SA welding.

Customer packing on request.

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