

# CARBO S- 1.4122

# CARBO T- 1.4122

## International standards

	S = solid wire	T = bare rod
Mat. No.	1.4122	
EN 12072	G Z 17 Mo H	17 Mo H
DIN 8556	SG-X35 CrMo 17	

## 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 temperature

Room temperature up to 450° C

### Base materials

1.4122 (G)X35CrMo17

### Recommendations for fabrication

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 <sub>m</sub> N/mm <sup>2</sup>	Yield strength R <sub>p0,2</sub> N/mm <sup>2</sup>	Elongation A <sub>5</sub> %	Hardness HRC
550	750	12	ca..45

### Weld metal analysis (typical, wt. %)

C	Si	Mn	Cr	Mo	Ni
0,4	0,5	0,5	16,5	1,1	0,5

### Gas types EN 439

S = solid wire	T = bare rod
M 12 / M 13	I1

### Current

	= +				= -				
Diameter mm	0,8	1,0	1,2	1,6	1,6	2,0	2,4	3,2	4,0
Welding amps (A) min.	80	120	180	250					
(A) max.	130	190	250	320					

### coils, weight

Rev. 001/13

B300 15 kg.

10 kg.