

DESCRIPTION

ThermaClad 420 deposit is a martensitic stainless steel. The deposit has good wear resistance and also provides good resistance to fire cracking.

TYPICAL DEPOSIT CHARACTERISTICS

Wear Properties Good
Hardness* (As welded) 43 – 48 HRC

* Three layer hardness on 1020 steel.

ALLOY TYPE

Martensitic Stainless Steel

TYPICAL APPLICATIONS

Typical applications include:

- Continuous Caster Rolls

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, In. (mm)	3/32 (2.4)
Current, Amp. DC+	300 – 400
Voltage	26 – 28
Wire Extension	1" – 1 1/4"
Flux Type	Stoody R-20

Diameter, In. (mm)	1/8 (3.2)
Current, Amp. DC+	400 – 500
Voltage	27 – 30
Wire Extension	1 1/4" – 1 1/2"
Flux Type	Stoody R-20

Diameter, In. (mm)	5/32 (4.0)
Current, Amp. DC+	450 – 600
Voltage	29 – 32
Wire Extension	1 1/4" – 1 1/2"
Flux Type	Stoody R-20

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
3/32" (2.4mm)	100# Coil	11827100
3/32" (2.4mm)	500# POP	11810400
1/8" (3.2 mm)	100# Coil	11827200
1/8" (3.2mm)	500# POP	11832200
1/8" (3.2mm)	750# POP	11873300
5/32" (4.0mm)	500# POP	11832300