



MIG 17/4MO

Classification

ISO 14343-A : G Z 17 4 Mo

Material N° : 1.4405

Description & Applications

Solid wire for joining and repairing steels of similar chemical composition.

Main applications: Repairing of Pelton* turbines.

* Trademark of Aubert&Duval

Base materials: **Martensitic stainless steels and castings:**

UNS	Alloy	EN/ Symbol	Material N°
J91540	CA6-NM	GX5CrNi13-4	1.4313
S41500		X3CrNiMo13-4	1.4313
		GX4CrNi13-4	1.4317
		GX5CrNiMo13-4	1.4407
		X5CrNiMo16-5	1.4405
		GX5CrNiMo16-5-1	1.4405

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	P	S	Fe
0.05	0.3	0.9	16.0	4.4	1.0	<0.03	<0.02	Rem.

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)
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Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG = +	1.0	120-200	24-28	EN 439 : M1 Ar + 2%CO ₂ 18-20 l/min
	1.2	140-220	24-28	
	1.6	180-260	24-30	

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