



TIG M13/0C

Old reference: TIG 420 / Finox14R

Classification

AWS A5.9 : ER420

N°Mat. : 1.4028

Description & Applications

Stainless filler metal used for hardfacing steel with 13% chromium designed to resist at atmospheric, water and steam corrosion

Main applications: Used for pipind, valves, taps with a service temperature up to 450°C

Typical Chemical Composition (%)

C	Si	Mn	Cr	P	S	Fe
0.3	0.5	0.55	13.0	<0.03	<0.02	Base

All Weld Metal Mechanical Properties

Hardness
~350 HB

Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	Ar : 6-12 l/min Back shielding : Argon / Nitrogen : 3-6 l/min

FT Fr-T060H-1411

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