

INERTFIL 420

MIG-MAG Wires Stainless and Heat resistant steels

Inertfil 420 is a solid wire for welding steel type AISI 420. These are self-hardening steels and usually require pre-heating and stress relieving treatments in order to obtain adequate ductility.

Classification	
AWS	A5.9: ER 420

Approvals	Grades

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
0.30	0.45	0.40	≤ 0.030	≤ 0.025	13.50	0.45	0.20	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) 20°C	Hardness
PWHT 750°C x 1h	≥ 400	≥ 450	≥ 20	≥ 47	-

Gas test: Acc. To EN 439: M13(Cargal1)

Shielding Gas: Acc. To EN 439: M13(Cargal1)

Materials

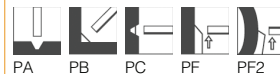
AISI 420, hardfacing harder than ER410

Storage

Keep dry and avoid condensation.

Current condition and welding position

DC+



Packaging data: BS300 Kg. 15

Diameters	1,0	1,2			