

FOR STAINLESS STEEL

AWS ER420

M-420

Typical applications

Welding of martensite stainless alloys of the 13%Cr types (STS 420)

The alloy is suitable for the first layer of corrosion resistant weld claddings

Typical chemical composition of wire (%)

C	Si	Mn	Ni	Cr
0.33	0.41	0.37	—	12.70

Typical mechanical properties of all-weld-metal

Shielding Gas	T · S N/mm ² (kgf/mm ²)	El (%)	IV (J)
Ar+2%O ₂	—	—	—

Package

Dia. (mm)	0.8	0.9	1.0	1.2	1.4	1.6
Spool. (kg)	5, 12.5, 20					
Pailpack.(kg)	200, 250			200, 250, 300		

Approved by