



IN COLLABORATION WITH
Kjellberg
 FINSTERWALDE
 ESTD. 1922



Kjellberg Finsterwalde Elektroden und Maschinen GmbH, Germany

Product Data Sheet

SUPERMIG 420

SS MIG WELDING WIRE
 Stainless and Heat resistant steels

Classification:

ASME SFA A5.9 :- AWS ER 420

Description: SUPERMIG 420 is a ER 420 type solid MAG welding wire supplied precision layer wound ,suitable for use with Ar-CO2 mix shielding gases. SUPERMIG 420 is mainly used for many surfacing operations and it is similar to SUPERMIG 410, but with higher chromium and carbon content , which increases the wear resistance .

Precision layer winding technologies ensure smooth, virtually trouble-free feeding.

Materials to be welded

AISI 420, hardfacing harder than ER410, X12Cr13

Typical Chemical Composition (%)

C	Mn	Si	Cr	Ni	Mo	Cu	S	P
0.25-0.40	0.60 Max	0.50 Max	12.00-14.00	0.60 Max	0.75 Max	0.75 max.	0.03 max.	0.03 max.

Typical All Weld Mechanical Properties

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO – V (J) 20° C
≥400	≥450	≥15%	≥47

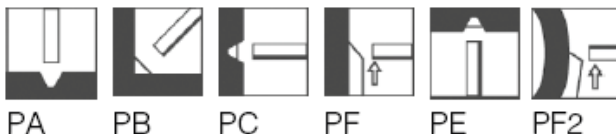
The chemistry and all weld mechanical properties will vary with the type of shielding gas used. Recommended shielding gas as per EN ISO 14175 : 98%Ar+2%O2, Ar+0.5%≤CO2≤5%

Welding Directions :- MIG welding can be performed as short, spray or pulsed arc. Short arc is preferably used for thin gauges, both for horizontal and positional welding. Spray arc increases the deposition rate. Welding with pulsed arc gives excellent possibilities for a good result in varying plate thicknesses in all positions. The highest flexibility using pulsed arc is achieved with 1.20 mm

Current Conditions:- DC (+)

Storage: - Keep dry and avoid condensation.

Welding position:-





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Recommended Welding Data:-

Diameter (mm)		0.8	1.0	1.2
Operating range				
Ar+1~2%CO ₂	Amp	40~120	80~160	100~210
	Volt	15~20	16~22	17~22
Ar+1~2%O ₂	Amp	160~210	180~280	200~300
	Volt	24~28	24~30	24~30

Packing Data:

Size (mm)	1.20	1.00	0.80
Weight (kg)	12.50	12.50	12.50

Revised on: 23/05/2012