MIG 17/4MO

Classification

ISO 14343-A : G Z 17 4 Mo
EN 4689 : X4CrNiMo16-5-1
AIR 9117 : Z8 CND17-04

Description & Applications

Solid wire for GMAW of stainless steels with similar chemical composition like X2CrNiMo13-4, APX4S*.

* Trademark of Aubert & Duval

Main applications: Repairing of Pelton turbine.

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	P	S	N
Min				15.00	4.00	0.80	-			0.02
Max	0.06	0.70	1.50	17.00	5.00	1.50	-	0.025	0.005	0.08
Type	0.05	0.30	0.90	16.0	4.4	1.0	0.10	0.02	0.003	0.03

All Weld Metal Mechanical Properties

	$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)	
Min	-	-	-	-	-
Max	-	-	-	-	-
Type	750	900	16	20°C	60

* After PWHT at 620°C/4h

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Current (A)	Voltage (V)	
GMAW = +	0.8 1.0 1.2 1.6	70 - 180 80 - 220 150 - 320 220 - 380	18 - 26 18 - 28 22 - 32 24 - 34	ISO 14175: M12 (Ar+0.5-5%CO_2) M13 (Ar+0.5-3%O_2) 15-20 l/min

Preheating of work-pieces at 100-150°C. Maintain temperature during welding and then, slow cooling at still air. Anneahling is advised at 580-620°C/4-8h.

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