



MIG M13/0C

Classification

AWS A5.9 : ER420

ISO 14343-A : G Z 13 H

Description & Applications

High Carbon content solid wire for GMAW used for hardfacing stainless steels with 13% Chromium designed to resist at atmospheric, water and steam corrosion with a service temperature up to 450°C.

Main applications: Harfacing of piping systems, valves, taps...

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	Nb	P	S	Co
Min	0.25			12.0				-			-
Max	0.40	0.5	0.6	14.0	0.6	0.75	0.75	-	0.03	0.03	-
Type	0.30	0.47	0.55	13.0	0.20	0.02	0.06	0.01	0.02	0.01	0.05

All Weld Metal Mechanical Properties

Hardness (as welded)
~50 HRC

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Current (A)	Voltage (V)	
GMAW = +	0.8	70 - 180	18 - 26	ISO 14175: M12 (Ar+0.5-5%CO ₂) M13 (Ar+0.5-3%O ₂) 15-20 l/min
	1.0	80 - 220	18 - 28	
	1.2	150 - 320	22 - 32	
	1.6	220 - 380	24 - 34	

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