



TIG M13/0C

Old reference: TIG 420 /
Finox14R

Classification

AWS A5.9 : ER420

ISO 14343-A : W Z 13 H

Description & Applications

High Carbon content solid rod for GTAW 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	0.50	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	Shielding Gas
TIG = -	ISO 14175 : I1 (Ar) 6-12 l/min Back shielding: I1 (Ar) / N1 (Nitrogen) : 3-6 l/min

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