

COR™STAIN 420 FC

DESCRIPTION

COR™STAIN 420 FC is a flux-cored, 13% chrome, martensitic stainless steel alloy. 420 FC is available in gas shielded, self-shielded, and submerged arc wires.

APPLICATIONS

420 FC is widely used for cladding steel mill rolls and components, and low alloy steels against corrosion and oxidation. Other uses include overlays for plastic and die cast dies, and also for joining 420 stainless steels.

PROCEDURE

The optimum preheat/interpass temperature is 600-800°F. However, this alloy is often welded with minimal preheat due to the size and nature of the base. Tempering at 400-700°F is advised. Double tempers are beneficial. Cool to room temperature in between tempers.

WELDING PARAMETERS

Type	Size	Volts	Amps	Shielding Gas/Stickout
MC-G	.045"	19-21	160-200	75%Ar-25%CO ₂
FC-G	1/16"	23-25	175-225	CO ₂
FC-G	3/32"	25-27	300-400	CO ₂
FC-G	1/8"	27-29	400-500	CO ₂

Self-shielded wires are available in 1/16"-7/64"; 1 1/2" stickout.

Submerged arc wires are available in 1/16"-5/32"; Use a neutral flux.

MECHANICAL PROPERTIES

Hardness: 51-54 Rc

CLASSIFICATION

AISI 420 Stainless Steel