

## MT-4462

## 1.4462

**TIG/MIG welding wire of nitrogenous ferritic-austenitic chrome-nickel-molybdenum-steel for welding stainless ferritic-austenitic compound steels suitable for working temperatures of up to +250°C.**

### Standard designation

Material No.	1.4462
AWS/ASME SFA-5.9	~ER 2209
EN ISO 14343-A	G/W 22 9 3 NL

### Main base metals

Stainless ferritic austenitic steel/cast steel, e.g.

1.4347	G-X 8 CrNi 26 7	1.4462	X 2 CrNiMoN 22 5
1.4417	X 2 CrNiMoSi 19 5	1.4582	X 4 CrNiMoNb 25 7
1.4460	X 8 CrNiMo 27 5		

As well as joint welding to mild steels, low-alloyed and stainless steels/cast steels.

### Mechanical properties of all – weld – metal (typical values)

Welding process			TIG	MIG
Gas shield			I1	M11
Thermal treatment			untreated	untreated
Test temperature			+20°	+20°C
		[°C]		
0.2%-yield strength	R <sub>p0.2</sub>	MPa	≥480	≥480
Tensile strength	R <sub>m</sub>	MPa	≥680	≥680
Elongation	A <sub>5</sub>	[%]	≥25	≥25
Impact strength	A <sub>v</sub>	[J]	LNB	LNB

### Average chemical composition of all - weld – metal (%)

C	Si	Mn	Cr	Mo	Ni	N
0,03	1,0	2,5	21,0-24,0	2,5-4,0	7,0-10,0	0,10-0,20

### Structure

Ferritic-austenitic

### Gas types applicable TIG

I1

### Gas types applicable MIG

M 12

### Approvals

TÜV, DB, CE

### TIG rod diameters, unit weights

Diameter [mm]	Length [mm]	Kg per box
1,60	1000	10,0
2,00	1000	10,0
2,40	1000	10,0
3,20	1000	10,0

### MIG welding wire

Diameter                      0,8mm                      1,0mm                      1,2mm

### Welding positions MIG acc.to EN ISO 6947

PA, PB, PF

### Welding positions TIG acc.to EN ISO 6947

PA, PB, PC, PF

### Current/Polarity TIG

= -

### Current/Polarity MIG

= +