Selectarc Inox 13/4

Stainless Electrode
With 13% Cr & 4% Ni

Classification

AWS A 5.4 : E410NiMo-15 EN 1600 : E 13 4 B 4 2
ISO 3581-A : E 13 4 B 4 2

Description & Applications

Basic coated electrode for repair and construction welding of martensitic CrNi steels of similar composition. These steels / castings are used for hydraulic turbines, pumps, valve bodies, compressor parts...Stable arc, easy slag removal, regular weld beads.

Base materials

Martensitic stainless steels and castings:

UNS	Alloy	EN/ Symbol	Material N°
J91540	CA6-NM	G-X5CrNi13-4	1.4313
S41500		X3CrNiMo13-4	1.4313
		G-X4CrNi13-4	1.4317
		G-X5CrNiMo13-4	1.4407
		X3CrNiMo13-4	1.4413
		G-X4CrNiMo13-4	1.4414

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	Fe
0.04	0.3	0.6	12.0	4.2	0.5	Rem.

All Weld Metal Mechanical Properties

$R_{p0,2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)
>630	>830	>15	+20℃ >50

After PWHT 580℃/8h

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x350	3,2x350	4,0x450
Current	(A)	90	130	150

Redrying 2h at 300℃. Guide electrodes with a sligh t declination, weld with a short arc. Preheat base material to 100-150℃ and keep this temperature dur ing welding. Cool down to room temperature and perform the PWHT.

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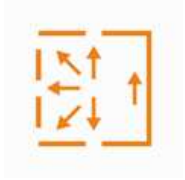

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