



# Selectarc Inox 13/4

*Stainless Electrode  
With 13% Cr & 4% Ni*

## Classification

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

EN 1600 : 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°C >50

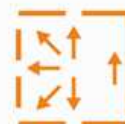
After PWHT 580°C/8h

## Welding Current & Instructions

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

Redrying 2h at 300°C. Guide electrodes with a slight declination, weld with a short arc. Preheat base material to 100-150°C and keep this temperature during welding. Cool down to room temperature and perform the PWHT.

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