



Selectarc Inox 17/4Mo

Basic Coated Electrode
16% Cr - 5% Ni – 1% Mo

Classification

ISO 3581-A : E Z 16 5 1 B 4 2

EN 1600 : E Z 16 5 1 B 4 2

Description & Applications

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

Base materials

Martensitic stainless steels and castings:

EN	Material N°
G-X4CrNiMo 16-5-1	1.4405
X4CrNiMo 16-5-1	1.4418

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	Fe
<0.04	0.3	0.6	16.0	5.0	1.0	Rem.

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
>650	>850	>13	+20°C >40

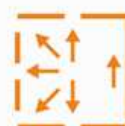
After annealing 8h/ 580°C.

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x300	3,2x350	4,0x450
Current	(A)	90	120	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.

ind.12



= +

Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.

www.fsh-welding.com - info@fsh-welding.fr