# Selectarc Inox 410NiMoB

*Stainless Electrode*
*With 12% Cr – 4% Ni*

## Classification

AWS A5.4 : E410NiMo-15 ISO 3581-A : E 13 4 B 4 2

## Description & Applications

Basic coated electrode with an alloyed core wire for repair and construction welding of martensitic Cr-Ni steels of similar composition. Stable arc, easy slag removal, regular weld beads. These steels/castings are used for hydraulic turbines, pumps, valve bodies, compressor parts...

**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 | Cu | Fe |
|---|---|---|---|---|---|---|---|
| 0.04 | 0.3 | 0.6 | 12.2 | 4.4 | 0.5 | 0.1 | Rem. |

## All Weld Metal Mechanical Properties

| $R_{p0,2}$ ( MPa ) | $R_m$ ( MPa ) | $A_5$ ( % ) | KV ( J ) | Hardness |
|---|---|---|---|---|
| >630 | >830 | >15 | +20°C >60 | ~300 HB |

After PWHT 600°C/4h

## Welding Current & Instructions

| Electrode | ØxL ( mm ) | 2,5x350 | 3,2x350 | 4,0x450 | 5,0x450 |
|---|---|---|---|---|---|
| Current | ( A ) | 80 | 110 | 150 | 180 |

Redrying 2h at 300°C. Guide electrodes with a slight declination, weld with a short arc. Preheat base material to 200-300°C and keep this temperature during welding. Cool down to room temperature and perform the PWHT.

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