Selectarc Inox 13/4 (DC+)

STAINLESS STEEL

DESCRIPTION

Basic coated electrode for repair and construction welding of martensitic Cr-Ni 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.

CLASSIFICATION

AWS A 5.4: E410NiMo-15 EN 1600: E 13 4 B 42 ISO 3581-A: E 13 4 B 42

BASE MATERIALS

410, 410S, 405, CA6-NM

PROCEDURE

Rebake electrodes 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.

MECHANICAL PROPERTIES*

Tensile strength:	> 120 381 psi (> 830 MPa)
Yield strength:	> 91 373 psi (> 630 MPa)
Elongation:	> 15 %
Impact (Charpy V):	> 50 J at +20ºC

* after PWHT 580°C/8h

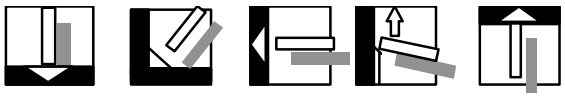
TYPICAL WELD METAL COMPOSITION (%)

C	Mn	Si	Cr	Ni	Mo	Fe
0.04	0.60	0.30	12.0	4.2	0.5	Rem

WELDING PARAMETERS

Diameter:	4.0 mm (5/32")	3.2 mm (1/8")	2.5 mm (3/32")
Amperage:	150-170 A	110-130 A	80-100 A

WELDING POSITIONS



1G/PA 2F/PB 2G/PC 3G/PF 4G/PE

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