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.

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