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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