Selectarc Inox 430B

Basic Coated Electrode

17% Cr

Classification

AWS A5.4 : E430-15 EN 1600 : E 17 B 6 2

ISO 3581-A : E 17 B 6 2

Description & Applications

Basic coated electrode for repair and construction welding on 17% Cr steels. Corrosion and scale resistant up to 950°C. Ferritic 17% Cr steels are s ensitive to embrittlement due to coarse grain growth, therefore often used only for cap passes. Stable arc, easy slag removal, regular weld beads. Used for surfacing on fittings and valves for gas, water and steam systems.

Base materials

Ferritic stainless steels for general use:

Alliage	EN	N° de Mat.
430	X6Cr17	1.4016
	X17CrNi16-2	1.4057
	G-X22CrNi17	1.4059
	X3CrTi17	1.4510
	X2CrAlTi18-2	1.4741
	X10CrAlSi18	1.4752

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	P	S	Fe
0.08	0.4	0.5	16.7	<0.60	<0.02	<0.10	<0.025	<0.015	Base

All Weld Metal Mechanical Properties

$R_{p0,2}$ (MPa)*	R_m (MPa)*	A_5 (%)*	Hardness
360	550	22	~250HB as welded

*After annealing 780°C/2h.

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x300	3,2x350	4,0x450	5,0x450
Current	(A)	80-100	110-130	120-150	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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