Selectarc Inox 410B

Stainless Electrode
With 13% Cr

Classification

AWS A5.4 : E410-15
ISO 3581-A : E 13 B 4 2

EN 1600 : E 13 B 4 2

Description & Applications

Basic coated electrode for repair and construction welding on heat resistant ferritic 14% Cr steels of similar composition. For surfacing on fittings and valves for gas, water and steam systems. Corrosion and scale resistant up to 900°C.Stable arc, easy slag removal, regular weld beads.

Main application: Hardfacing of valve body used for gas, water and steam transport system..

Base materials

Ferritic stainless steels for general use:

UNS	Alloy	EN	Material N°	UGINE
S41000	410	X12Cr13	1.4006	
S41008	410S	X6Cr13	1.4000	UGINOX F 13 S
S42000	420	X20Cr13	1.4021	
		X7Cr14	1.4001	
		X15Cr13	1.4024	

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Fe
0.1	0.5	0.6	13.0	Rem.

All Weld Metal Mechanical Properties

$R_{p0,2}$ (MPa)	R_m (MPa)	A_5 (%)	Hardness
>450	>650	>18	Approx. 250 HB

After PWHT 750°C/2h

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x350	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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