R-INOX B 13/4

Basic coated high alloyed, low hydrogen type electrode for welding martensitic and martensitic-ferrite steels.

CLASSIFICATION : AWS/SFA-5.4: E 410NiMoL-15
EN 1600 : 1997 E 13 4 B 6 2

APPROVAL :

CHARACTERISTICS : Basic coated low hydrogen electrode suitable for similar soft martensitic and martensitic-ferrite rolled, forged and cast steels, mainly suitable in the construction of hydro turbines, compressors. Resistant to corrosion from water, steam and sea water atmosphere. very balance alloying components then weld deposit yields very good, ductility and toughness with high cracking resistance despite of its high metal recovery approx 130 %.

APPLICATION :

1) Surfacing of high pressure valves, turbine blades, guide vans and runners.
2) Pulp and paper plant equipments similar corrosion resisting chromium steel erosion.
3) Pitting and impact value.

RE-DRY CONDITION : Re-Dry the electrode at 350°C for 1 hrs before use.

ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	S	P	Cr	Ni	Mo
0.060Max.	0.80	0.50	0.020Max.	0.020Max.	11.00-14.00	4.00-5.00	0.40-0.70

ALL WELD MECHANICAL PROPERTIES:(As welded)

YS (N/mm^2)	UTS (N/mm^2)	EL % (l=5d)	Impact **0°C**
≥830	≥1000	≥8	≥35

ALL WELD MECHANICAL PROPERTIES:(As PWHT annealed 620°C/8 hrs)

YS (N/mm^2)	UTS (N/mm^2)	EL % (l=4d)	Impact **0°C**
≥620	≥830	≥15	≥50

DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (Dia)	Size(inch) (Dia)	Current Condition (DC+) Amps	Kg/pkt.	Kg/Case
2.50/ 2.40 X 350	3/ 32" X 14"	50-90	5	20
3.15/ 3.20 X 450	1/ 8" X 18"	100-140	5	20
4.00 X 450	5/ 32" X 18"	130-190	5	20
5.00 X 450	3/ 16" X 18"	160-260	5	20

Customer packing on request.