

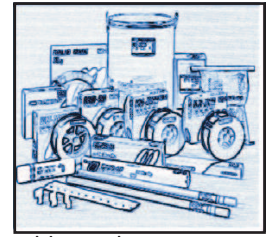
Stainless Steel Electrodes

ANU BOND 13/4 (E 410 - 15 NiMoX) SFA 5.4 AWS E 410 - 15 NiMox

Stainless Steel Electrodes

Application :

Welding and surfacing of Turbines, Armature, Valves, Pumps. Welding for similar composition of casting steel. Welding of martensitic / ferritic stainless steel of 13% Cr, 4% Ni.



Characteristics :

It is a heavy coated basic type hydrogen controlled electrode, used for welding and surfacing of 13%Cr, 4% Ni type martensitic- ferritic chromium steel. It give impact properties upto - 29 °C the weld metal has radiographic quality and easily removable slag.

Notes On Usage :

- 1) Preheat the job at 150-200 °C & PWTH. At 595-620 °C for one hour soaking.
- 2) keep the current as low as possible
- 3) Remove rust, water, oil, paint etc. From groove
- 4) Dry the electrodes at 350 °C for 60 minute before use.

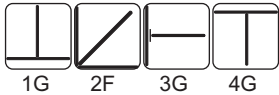
Chemical composition of All-Weld metal (%) as per AWS

C	Mn	Si	P	S	Cr	Ni	Mo
0.06 Max	1.00 Max	0.90 Max	0.04 Max	0.03 Max	11.0-12.5	4.0-5.0	0.4-0.70

Mechanical properties of all-weld metal as per AWS

UTS (N/mm ²)	Elongation (L=4d) %
760 Min	15% Min

Welding Positions



Packaging & Welding Current

SIZE (mm)	KG Per Packet	KG Per Carton	Current (Amps)	In Amps
2.50 x 350	2	12	DC (+)	60 - 80
3.15 x 350	2	12		80 - 120
4.00 x 350	2	12		110 - 160
5.00 x 350	2	12		150 - 190

