

**Stainless Steel Electrodes**

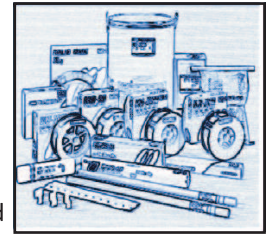
**ANU BOND 13 (E 410 - 15)**

SFA 5.4 AWS E 410 - 15

**Stainless Steel Electrodes**

**Application :**

Turbines, armature valves & pumps.



**Characteristics :**

This electrodes is used for welding and surfacing of 13% chromium steel. It is also recommended for using in turbines, armature valves and pumps. The weld metal is of radiographic quality, resistant to friction, corrosion and oxidation.

**Notes On Usage :**

- 1) Preheat the job at 150-200° C & PWHT. at 730 - 760° C for one hour soaking
- 2) keep the current as low as possible
- 3) Remove rust,water, oil, paint etc. From growe

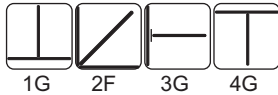
**Chemical composition of All-Weld metal (%) as per AWS**

C	Mn	Si	P	S	Cr	Ni	Mo
0.12 Max	1.00 Max	0.90 Max	0.04 Max	0.03 Max	11.0-13.5	0.70 Max	0.75 Max

**Mechanical properties of all-weld metal as per AWS**

UTS (N/mm <sup>2</sup> )	YS (N/mm <sup>2</sup> )	Elongation ( L=4d ) %
520 Min	470 Min	20.0% 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 - 110
4.00 x 350	2	12		100 - 140
5.00 x 350	2	12		140 - 180

