

# ROYAL CHROME -13 / 4 (E 410 NiMo -16)

SFA 5.4 AWS E 410 NiMo-16

## Applications

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 on Usage

It is a heavy coated hydrogen controlled electrode, used for welding and surfacing of 13% Cr, 4% Ni type martensitic – ferritic chromium steel. The weld metal has radiographic quality and easily removable slag.

## Notes On Usage

- Preheat the job at 150-200°C & PWHT. at 595 - 620°C for one hour soaking
- keep the current as low as possible
- Dry the electrodes at 300°C for 60 minute before use

## Welding Positions



## Packing

Vaccum packing

STAINLESS STEEL ELECTRODES

## Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo%
0.06 Max	1.00 Max	0.90 Max	0.030 Max	0.040 Max	11.0 – 12.50	4.0 – 5.0	0.40 – 0.70

## Mechanical Properties Of Weld Metal

U.T.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %
760	15

## Packing and Welding Current

SIZE ( mm )	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 x 350	2	10	DC (+)	60 – 80
3.15 x 350	2	10		80 – 120
4.00 x 350	2	10		110 – 160
5.00 x 350	2	10		150 – 190