

ROYAL CHROME – 13 / 4 (E 410 – 15 NiMoX)

SFA 5.4 AWS E 410 – 15 NiMoX EN ISO 3581 A E 13 4 B 22

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.

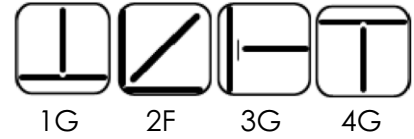
Characteristics on Usage

martensitic – ferritic chromium steel. It gives impact properties upto minus 29o C, the weld metal has radiographic quality and easily removable slag.

Notes On Usage

- Preheat the job at 150-200°C & PWHT. at 595 - 620oC for one hour soaking
- keep the current as low as possible
- Remove dirt such as oil and dust from the groove.
- Dry the electrodes at 350oC for 60 minute before use

Welding Positions



Packing

Vaccum packing

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 ²)	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