


Technical data sheet 011121MBA	Coated SMAW Electrode WA CHROMECORE V 410-E	 Welding Alloys
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CLASSIFICATION

ASME IIC SFA 5.4 / AWS A 5.4: E410-16
EN ISO 3581: E13 R 5 3

DESCRIPTION

- All positional, rutile basic coated, martensitic stainless steel electrode
- 13% Cr - low carbon deposit
- The electrode distinguishes itself by a stable arc, easy slag removal and regular weld beads
- The deposit offers good resistance to thermal shock, rubbing abrasion and corrosion

APPLICATIONS

This electrode is suitable for welding of high strength type 410 12% Cr Martensitic stainless steels. Developed primarily for CA-15 & BS410C21 Castings. Typically, applications include: hydrocrackers, reaction vessels, valve bodies, and turbine sections.

TYPICAL ALL-WELD METAL ANALYSIS [%]

C	Si	Mn	Cr	Ni	Mo	Cu
0.07	0.3	0.7	13	0.5	0.4	0.03

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2[MPa]	A ₅ [%]	CVN [J]
610	455	34	-

These results are typically obtained after post-weld heat treatment at 740°C for 1 hour.

OPERATING CONDITIONS

Electrode Ø x L [mm]	2.5 x 350	3.2 x 450	4.0 x 450	5.0 x 450
Current [A]	70-100	90-140	120-180	160-220
= +	~ 70V			

Re-drying: 2h at 350°C, if necessary.

WELDING POSITIONS

All positions

PACKAGING

Electrode Ø x L [mm]	2.5 x 350	3.2 x 450	4.0 x 450	5.0 x 450
Weight/box [kg]	2.0	2.0	2.0	2.0

Other packaging and other sizes: please consult us