

**Technical
data sheet**

011121MBA

**Coated SMAW Electrode
WA CHROMECORE B 16 5 1-E****CLASSIFICATION**

EN 1600: Z 16 5 1 B 42
EN 14700: E Fe7

DESCRIPTION

- 16% Cr - 5% Ni - 1% Mo soft martensitic basic coated electrode
- The deposit gives excellent resistance to cavitation and to stress corrosion cracking.
- The electrode distinguishes itself by a soft arc, easy slag removal and regular weld beads.

APPLICATIONS

Welding corrosion resistant martensitic-ferritic rolled, forged and cast steels of similar composition.

Rebuilding and repairing casting defects, fabrication and rebuilding work on propellers, shafts and parts used in water turbine and pump construction.

A post-weld heat treatment at 580°C - 620°C is advised to obtain a tempered martensite that combines ductility, corrosion resistance and cavitation resistance.

Examples of materials to be welded:

EN Designation	Material number
X4 CrNiMo 16-5-1	1.4418
X5 CrNiMo 16 5	1.4405

TYPICAL ALL-WELD METAL ANALYSIS [%]

C	Si	Mn	Cr	Ni	Mo
<0.04	0.3	0.6	16	5	1

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2%[MPa]	A ₅ [%]	CVN [J]
850	650	13	+20°C: 40

These results are typically obtained after post-weld heat treatment at 580°C for 2 hours.

OPERATING CONDITIONS

Electrode Ø x L [mm]	2.5 x 350	3.2 x 350	4.0 x 350
Current [A]	90	120	135
= +	~ 70V		

Re-drying: 2h at 300°C, if necessary.

WELDING POSITIONS

EN ISO 6947: PA, PB, PC, PF, PE
ASME IX: 1G, 2G, 2F, 3G, 4G

PACKAGING

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

Other packaging and other sizes: please consult us