


Technical data sheet <small>011121MBA</small>	Coated SMAW Electrode WA CHROMECORE B 410-E	
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CLASSIFICATION

ASME IIC SFA 5.4 / AWS A 5.4:	E410-15
EN ISO 3581-A:	E 13 B 42
ASME IX Qualification	QW-432 F-N° 1 QW-442 A-N° 6

DESCRIPTION

- Basic coated electrode
- 13% Cr martensitic stainless steel deposit
- Complements Welding Alloys cored wires CHROMECORE 410-G and CHROMECORE S 410-G

APPLICATIONS

WA CHROMECORE B 410-E is suitable for welding steels with similar chemical compositions. Primarily used for sealing surface applications on fittings made of unalloyed or low-alloy steels for operating temperatures up to 450°C

Examples:

AISI	UNS	Material number	EN Symbol
403	S40300	1.4000	X7Cr13
CA15	J91150	1.4008	G-X12Cr14
429	S42900	1.4001	X7Cr14
420	S42000	1.4021	X20Cr13
405	S40500	1.4002	X7CrAl13
410	S41000	1.4024	X15Cr13
410	S41000	1.4006	X10Cr13

TYPICAL ALL-WELD METAL ANALYSIS [%]

C	Mn	Si	Cr
0.1	0.6	0.5	13

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

PWHT	Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]
2 hours at 750°C	650	450	18

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

PWHT	Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]
2 hours at 750°C	710	610	20

Typical hardness: 250 HB

OPERATING CONDITIONS

Electrode ØxL [mm]	2.5 x 350	3.2 x 350	4.0 x 450	5.0 x 450
Current [A]	80 - 100	110 - 130	120 - 150	150 - 180
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Re-drying: 2 hours at 300° C

WELDING POSITIONS

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

PACKAGING

Electrode ØxL [mm]	2.5 x 350	3.2 x 350	4.0 x 450	5.0 x 450
Weight/box [kg]	5			

Other packaging and other sizes: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.