



Selectarc Inox 410B

Stainless Electrode
With 13% Cr

Classification

AWS A5.4 : E410-15
ISO 3581-A : E 13 B 4 2

EN 1600 : E 13 B 4 2

Description & Applications

Basic coated electrode for repair and construction welding on heat resistant ferritic 14% Cr steels of similar composition. For surfacing on fittings and valves for gas, water and steam systems. Corrosion and scale resistant up to 900°C. Stable arc, easy slag removal, regular weld beads.

Main application: Hardfacing of valve body used for gas, water and steam transport system..

Base materials

Ferritic stainless steels for general use:

UNS	Alloy	EN	Material N°	UGINE
S41000	410	X12Cr13	1.4006	
S41008	410S	X6Cr13	1.4000	UGINOX F 13 S
S42000	420	X20Cr13	1.4021	
		X7Cr14	1.4001	
		X15Cr13	1.4024	

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Fe
0.1	0.5	0.6	13.0	Rem.

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	Hardness
>450	>650	>18	Approx. 250 HB

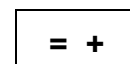
After PWHT 750°C/2h

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x350	3,2x350	4,0x450	5,0x450
Current	(A)	80-100	110-130	120-150	150-180

Redrying 2h at 300°C. Guide electrodes with a slight declination, weld with a short arc. Preheat base material to 200-300°C and keep this temperature during welding. Cool down to room temperature and perform the PWHT.

ind.12



Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.