



Selectarc Inox 430MoB

Basic Coated Electrode
16% Cr – 1% Mo

Classification

ISO 3581-A : E Z 17 Mo B 6 2

EN 1600 : E Z 17 Mo B 6 2

Description & Applications

Basic coated electrode for surfacing seats on water, steam and gas valves. Used at service temperatures up to 450°C. Stable arc, easy slag removal, regular weld beads.

Base materials

| EN | Material N° |
|--------------|-------------|
| G-X35CrMo 17 | 1.4122 |

Typical Weld Metal Composition (%)

| C | Si | Mn | Cr | Ni | Mo | Fe |
|------|-----|-----|------|-----|-----|------|
| 0.15 | 0.3 | 0.3 | 16.0 | 0.5 | 1.1 | Rem. |

All Weld Metal Mechanical Properties

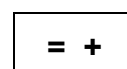
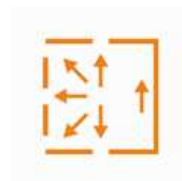
Hardness
42HRC (as welded)
After annealing 2h/ 780°C.

Welding Current & Instructions

| Electrode | ØxL (mm) | 2,5x300 | 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.

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