

selectarc

Inox 13/1

**Stainless Electrode
With 13% Cr & 1% Ni**


FSH WELDING GROUP
INNOVATIVE WELDING CONSUMABLES
www.fsh-welding.com

Classification

ISO 3581-A : E Z 13 1 B 42

Description & Applications

Basic coated electrode for repair and construction welding of martensitic Cr-Ni cast steels of similar composition.

These steels / castings are used for hydraulic turbines, pumps, valve bodies, compressor parts...

Stable arc, easy slag removal, regular weld beads.

Base materials:

Martensitic stainless steels and castings:

UNS	Alloy	EN/ Symbol	Material N°
		X2CrNi12	1.4003
		GX7CrNiMo12-1	1.4008
		X8CrNi13-1	1.4018
		GX20CrNi14	1.4027

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	Fe
0.04	0.3	0.6	12.5	1.2	0.1	0.1	Rem.

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)
520	700	18	+20°C 55

After PWHT 680°C/8h

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x350	3,2x350	4,0x450
Current	(A)	90	130	150

Redrying 2h at 300°C. Guide electrodes with a slight declination, weld with a short arc. Preheat base material to 100-150°C and keep this temperature during welding. Cool down to room temperature and perform the PWHT.



1G/PA



2F/PB



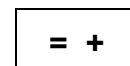
2G/PC



3G/PF



4G/PE



ind.10