

Standards

TS EN ISO 3581-A	: E 13 4 B 42
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AWS A5.4	: E 410 NiMo-15

**Chemical Composition of
Weld Metal % (Typical)**

C	Si	Mn	Mo	Ni	Cr
0.04	0.2	0.45	0.5	4.2	12.3

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20°C)	Elongation (L ₀ =5d ₀) (%)	Hardness (HB)
min. 500	min. 760	min. 47 J	min. 15	~360

Typical Base Material Grades

- X5CrNi 13 4, G-X5CrNi 13 4, X6Cr13, G-X5CrNi 13 6

Features and Applications

- Electrode with rutile coating on alloyed core-wire
- Applicability in welding Cr-Ni -alloyed austenitic high-temperature steels
- Usability in welding at all positions except for vertical downward position
- Applicability in joint-welding and surfacing of heat-resisting similar-type steels and steel castings.
- Serviceability at temperatures of values up to 700 °C
- Resistance to fracture and corrosion
- Creep resistance at high temperatures being higher than that of the electrode ELOX R 308 L
- Re-drying: 300° - 350°C / min. 2 h

Welding Positions

Current Type

D.C.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101473	2.50 x 250	3/32 x 10"	50 - 90	1500
3010101478	3.20 x 350	1/8 x 14"	90 - 110	3260
3010101483	4.00 x 350	5/32 x 14"	110 - 160	4930

Approvals: TSE, CE, SEPRO, GOST-R