Standards

TS EN ISO 3581-A	: E 13 B 22
EN ISO 3581-A	: E 13 B 22
AWS A5.4	: E 410-15

Chemical Composition of Weld Metal % (Typical)

C	Si	Mn	Cr
0.07	0.7	0.8	13.5

Mechanical Properties

Yield Strength (N/mm^2)	Tensile Strength (N/mm^2)	Impact Strength (ISO-V/+20°C)	Hardness (HB)	
			as welded	750°C/2h/furnace
min. 450	650-800	min. 15 J	~350	200

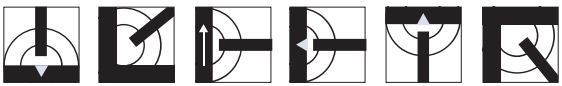
Typical Base Material Grades

- X6Cr 13, X6CrAl 13, X15Cr 13, X10Cr 13, G-X10Cr 13

Features and Applications

- 13% Cr used in the joining and surfacing welding of martensitic and martensitic-ferritic steels with 13% Cr and steel casts.(This electrode is also strong at filling in the surfaces of gas, water and steam armatures)
- Annealing at 750°C for 2 hours, cooling down to room temperature in the furnace
- Re-drying: 300°C - 350°C / min. 2h

Welding Positions



Current Type

D.C.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101458	2.50 x 250	3/32 x 10”	50 - 90	1500
3010101463	3.20 x 350	1/8 x 14”	80 - 120	3140
3010101468	4.00 x 350	5/32 x 14”	110 -160	4690

Approvals: TSE, CE, SEPRO