

Standards

TS EN ISO 3581-A	: E 17 B 22
EN ISO 3581-A	: E 17 B 22
AWS A5.4	: E 430 - 15

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

C	Si	Mn	Cr
0.08	0.5	0.4	17.0

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation (L ₀ =5d ₀) (%)	Hardness (HB)	
			as welded	750°C/2h/furnace
min. 350	540-660	min. 20	~270	~200

Typical Base Material Grades

- X6CrTi 17, X20CrNi17-2, 431, 430 Ti

Features and Applications

- Mainly used for corrosion-resistant, wear-resistant surfacing applications
- Preferably for surfacing on sealing faces of gas, water and steam valves
- Scaling resistance up to 900°C
- Weld metal protector hardness up to 500°C

Welding Positions

Current Type

D.C.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101503	2.50 x 250	3/32 x 10"	50 - 90	1400
3010101508	3.20 x 350	1/8 x 14"	80 - 120	3000
3010101513	4.00 x 350	5/32 x 14"	110 - 160	4600

Approvals: TSE, CE, SEPRO