Stainless Steel Electrode

ELOX B 430 Mo

Standards

TS EN ISO 3581-A : E Z 17 Mo B 22
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Chemical Composition of Weld Metal % (Typical)

C	Si	Mn	Mo	Cr
0.2	0.5	0.5	1.2	17.0

Mechanical Properties

Yield Strength (N/mm^2)	Tensile Strength (N/mm^2)	Elongation ($L_o=5d_o$) (%))	Hardness (HB)	
			as welded	750°C/2h/furnace
min. 490	650-750	min. 15	~400	~250

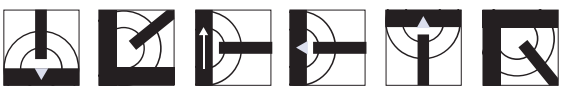
Typical Base Material Grades

- GS-C 25, X22CrNi 17, 41Cr4

Features and Applications

- Basic coated alloyed core wire electrode with good weldability in all positions except vertical-down
- Mainly used for hard surfacing, corrison resistant, wear resistant
- Preferably employed for sealing faces of gas, water and steam valves
- In the machined condition, at least a two-layer buildup should remain on the surface
- The weld metal features retention of hardness up to 500°C
- Sea water resistant, scalling resistant up to 900°C
- Preheating as required by the base metal, with temperatures between 100°C and 200°C being generally sufficient (for joining operations 250°- 400°C)
- Annealing at 650°C - 750°C may be carried out to improve the toughness values in the weld metal and in the transition zone

Welding Positions



Current Type

D.C.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101518	2.50 x 250	3/32 x 10”	50 - 90	1650
3010101523	3.20 x 350	1/8 x 14”	80 - 120	3030
3010101528	4.00 x 350	5/32 x 14”	110 - 160	4630

Approvals: TSE, CE, SEPRO