Stainless Steel Electrode

ELOX BS 410 Ni Mo

Standards

TS EN ISO 3581-A	: E 13 4 B 62
EN ISO 3581-A	: E 13 4 B 62
AWS A5.4	: E 410NiMo-25

Chemical Composition of Weld Metal % (Typical)

C	Si	Mn	Mo	Ni	Cr
0.05	0.3	0.5	0.5	4.5	11.5

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. 600	800-980	min. 47 J	min. 15	~270

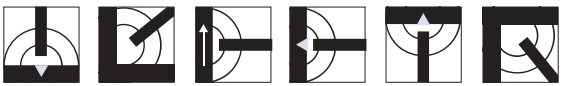
Typical Base Material Grades

- X5CrNi 13 4, G-X5CrNi 13 4, X6Cr 13, G-X5CrNi 13 6

Features and Applications

- Basic coated electrode for welding similar corrosion-resistant, martensitic and martensitic-ferritic rolled, forged and cast steels
- Used in the construction of hydroturbines, compressors and steam power plants
- Resistant to corrosion caused by water, steam and sea water atmosphere
- Excellent slag removability and smooth bead appearance
- Metal recovery approx. 130% Out-of-position weldability
- Preheating and interpass temperatures of thick-walled components 100°C-160°C
- Tempering temperature 580°C-620°C
- Re-drying: 300°C - 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
3010101488	2.50 x 350	3/32 x 14”	70 - 110	1960
3010101493	3.20 x 350	1/8 x 14”	110 - 150	3630
3010101498	4.00 x 350	5/32 x 14”	150 - 190	5550

Approvals: TSE, CE, SEPRO