

Standards

AWS A5.23 : ~ EC 410 NiMo

Chemical Composition of Weld Metal (Typical)

C	Si	Mn	Cr	Ni	Mo	V	Nb
0.13	1.00	2.00	12.5	2.5	1.0	0.2	0.15

Mechanical Properties

Hardness (HRC)	
Single Pass	3 Pass
40	45

Typical Base Material Grades

- Applicability in welding of martensitic and martensitic-ferritic materials used in toolsof rolling forging and steel casting operations. Continuous casting rollers particularly or iron-steel productions plants, relays, rolls, valves, used in gas/water/steam environments, flanges, compressions

Features and Applications

- A tubular wire for submerged arc welding of martensitic stainless steels
- Good resistance to corrosion and thermal fatigue
- It used with GeKa ELIFLUX BSS-F flux for surfacing continuous casting, rollers
- Weld metals of martensitic micro-structure
- It is used in combination with GeKa ELIFLUX BSS-F

Resistance Type and Level

Friction



Impact



High Temp.



Thermo Shock



Corrosive



Crack Resistance



Machining



Current Type

D.C (+)

Operating Data

Product Code	Diameter (mm) / (inch)		Package Weight (Kg)
3010700007	2.40	3/32	200

Approvals: SEPRO