

4115 HL

CATEGORY SMAW Stick Electrodes

TYPE High recovery, corrosion resistant stainless steel stick electrode

APPLICATIONS Hardfacing shafts from stainless steel parts, molt repairs, rebuilding pump parts etc. Suitable for plating and joining equal and similar ferritic Cr-steels and cast steels. Proper weldings are subject to the recommended heat treatment. This alloy is specially suitable for sealing surfaces on water-, steam and gas-valves, especially for sulphuric gases. The deposit is resistant to seawater, thin acids and scale resistant in air and oxidizing gases up to 950°C . The weld deposit can be tempered.

PROPERTIES High deposition rate and excellent weldability on DC +. Stainless steel alloy for joining and cladding 17% Chromium alloys and cladding components where heat and corrosion resistance simmlar to AISI 304 is required. The weld deposit can sustain working temperatures up to 450° C. and will offer a high hardness and wear resistance.

CLASSIFICATION

AWS	A 5.4: ~E 430HMo-26
EN ISO	3581-A: EZ 17 Mo R 52
DIN: W.Nr.	1.4115
DIN	8556: E 17 Mo B20+

SUITABLE FOR 1.4122 (G)X35CrMo17, 1.4313, 1.4000, 1.4001, 1.4002, Cast steels

WELDING POSITIONS:



WELD DEPOSIT WEIGHT % (TYPICAL)

C	Mn	Si	Cr	Ni	Mo
0.18	0.7	0.4	16-17	0.15	0.8-1.5

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc / HB
				-20°C	-40°C	-60°C	
AW							43 HRc
PWHT 720°C/2hr	500	700	15				200 HB

AW: as welded / PWHT: post weld heat treatment

WELDING PARAMETERS PACKING

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A)	kg / can	kg / 6pack	kg / 1000
2.5	300	80-120			
3.2	350	100-160			
4.0	450	160-220			

REDRYING TEMPERATURE 300°C/2hr