

4455 Ti

CATEGORY SMAW Stick Electrodes

TYPE SMAW electrode for welding Cr-Ni-Mo steels.

APPLICATIONS The electrode is suitable for welding corrosion-resistant Cr-Ni-Mo steels, austenitic steels, non-magnetic, cast steels and cold tough steels.

PROPERTIES Extreme stable arc on both AC and DC+ with no spatter losses. The slag is self lifting and leaves a fine rippled shiny surface.

CLASSIFICATION

AWS	A 5.4:
EN ISO	3581-A: EZ 20 16 3 Mn 3 LR 32
DIN: W.Nr.	1.4455
DIN	8556: E 18 15 3 LR 23

SUITABLE FOR

APPROVALS CE approved

WELDING POSITIONS:



WELD DEPOSIT WEIGHT %

C	Mn	Si	Cr	Ni	Mo	Fe
<0.03	2.5-4.0	<0.9	18-20	14-16.5	2.6-3.0	Rem

MECHANICAL PROPERTIES (TYPICAL)

Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				20°C	-40°C	-196°C	
AW	440	640	35			45	

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A) DC+/AC	kg / can	kg / 6pack	kg / 1000
2.0	300	40-60	2.5	15	12.2
2.5	300	60-90	2.5	15	18.8
3.2	350	80-110	2.6	15.6	35.6
4.0	350	100-150	2.8	16.8	54.0
5.0	450	155-220	3.2	19.2	96.97

REDRYING TEMPERATURE 300°C/2hr (not often required)