CR-40 PREMIARC™

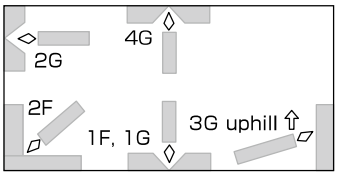
Stick electrode

Features:
- Suitable for 13%Cr stainless steels such as 403 and 410 types.
- Preheat: 200~400℃

Classification: AWS A5.4 E410-16

Redrying Conditions: 300~350℃x0.5~1h
Identification color: 1st Purple
Polarity: AC, DCEP

Welding Positions:



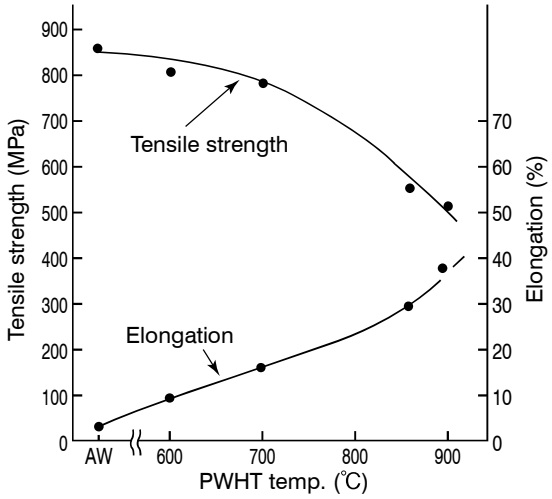
Packaging data

ϕ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	300	2	20	18	300W, 100H, 330L
3.2	350	5	20	30	175W, 120H, 380L
4.0	400	5	20	54	175W, 120H, 430L
5.0	400	5	20	83	175W, 120H, 430L

Composition (all-weld metal mass%)

	Typical (AC)	Guaranty [a]
C	0.06	0.12
Si	0.47	0.90
Mn	0.3	1.0
P	0.02	0.04
S	0.01	0.03
Ni	0.1	0.7
Cr	12.8	11.0~13.5
Mo	0.04	0.75
Cu	0.02	0.75

Note: [a] Single values are maximum.



Mechanical properties vs. PWHT temp.

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	290	-
TS (MPa)	510	450min.
El on 4d (%)	33	20min.
PWHT (℃xh)	850x2	

Welding parameters (A)

ϕ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.6	50~85	45~80
3.2	70~115	65~110
4.0	95~145	85~135
5.0	135~180	-