CR-40Cb PREMIARC™

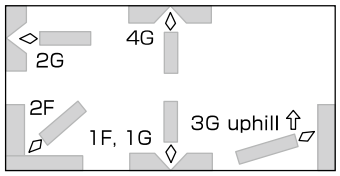
Stick electrode

Features:
- Suitable for 13%Cr stainless steels such as 403, 410 and 405 type.
- Preheat: 100~250℃

Classification: AWS A5.4 E409Nb-16

Redrying Conditions: 300~350℃x0.5~1h
Identification color: 1st Purple, 2nd Orange
Polarity: AC, DCEP

Welding Positions:



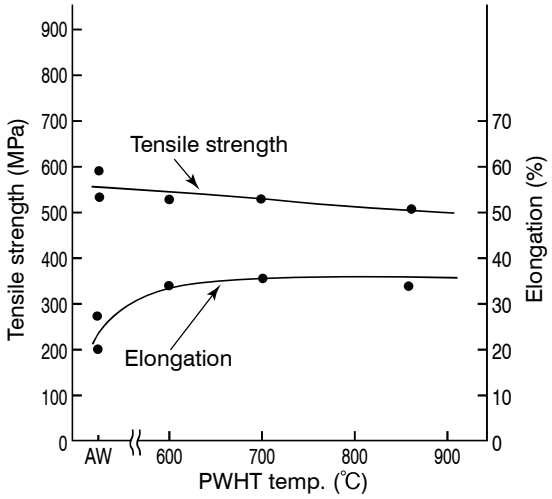
Packaging data

ϕ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	300	2	20	17	300W, 100H, 330L
3.2	350	5	20	31	175W, 120H, 380L
4.0	400	5	20	53	175W, 120H, 430L
5.0	400	5	20	82	175W, 120H, 430L

Composition (all-weld metal mass%)

	Typical (AC)	Guaranty [a]
C	0.09	0.12
Si	0.40	1.00
Mn	0.3	1.0
P	0.02	0.04
S	<0.01	0.03
Ni	0.1	0.6
Cr	12.9	11.0~14.0
Mo	0.05	0.75
Cu	0.03	0.75
Nb+Ta	0.81	0.50~1.50

Note: [a] Single values are maximum.



Mechanical properties vs. PWHT temp.

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	270	-
TS (MPa)	500	450min.
El on 4d (%)	35	20min.
PWHT (℃xh)	850x2	

Welding parameters (A)

ϕ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.6	60~85	50~80
3.2	80~115	65~105
4.0	100~145	95~140
5.0	140~180	-