

BÖHLER FOX CN 13/4 SUPRA

Basic stick electrode, high-alloyed, stainless

Classifications

EN ISO 3581-A

AWS A5.4

E 13 4 B 4 2

E410NiMo-15

Characteristics and typical fields of application

Basic electrode, core wire alloyed, low-hydrogen suited for welding similar soft-martensitic and martensitic-ferritic rolled, forged, and cast steels. Mainly used in the construction of hydro turbines, compressors. Resistant to corrosion from water, steam and sea water atmosphere. Thanks to an optimum balance of alloying components the weld deposit yields very good ductility and toughness & cracking resistance despite of its high strength.

Excellent slag removability, smooth bead appearance and low hydrogen weld metal (HD \leq 5 ml/100 g). Out of position weldable except vertical down.

Base materials

1.4317 GX4CrNi13-4, 1.4313 X3CrNiMo13-4, 1.4407 GX5CrNiMo13-4, 1.4414 GX4CrNiMo13-4 ACI Gr. CA 6 NM, S41500

Typical analysis of all-weld metal (wt%)											
	С	Si		Mn		Cr		Ni		Мо	
wt-%	0.03	0.3		0.6		12.2		4.5	0.5		
Mechanical properties of all-weld metal											
Condition	Yield strength $R_{p0,2}$		Tensile strength R_m		Elongation A $(L_0=5d_0)$		In IS	Impact work ISO-V KV J			
	MPa		MPa		%		+2	+20 °C		°C	−60 °C
u	880		1060		13		3	35			
а	680 (≥ 500)		930 (≥ 760)		18 (≥ 15)		7	70			55
q	670 (≥ 500)		850 (≥760)		18 (≥ 15)		1	05			
u untreated, as welded a annealed, 600 °C/2 h / air q quenched/tempered, 950 °C/0.5 h / air 600 °C/2 h / air											
Operating data											
	Polarity: DC(+)	Redrying if necessary: 300 – 350 °C, min. 2 h		Electrode identification: FOX CN 13/4 SUPRA 410NiMo- 15 E 13 4 B		ode ation: 13/4 0NiMo- 4 B	ø (m 3. 4.	nm) L mm .2 350 .0 350		Amps A 90 – 110 120 – 145	
Preheating and interpass temperatures of heavy-wall components 100-160°C. Maximum heat input 15 kJ/cm. Post weld heat treatment at 580-620°C.											
Approvals											
TÜV (0981.), SEPROZ, CE											

All information provided is based upon careful investigation and intensive research. However, we do not assume any liability for correctness and information is subject to change without notice.