

4015 HL-Kb

CATEGORY SMAW Stick Electrodes

TYPE High recovery, corrosion resistant stainless steel alloy without Nickel

APPLICATIONS Joining and cladding 17% Chromium alloys and cladding components where heat and corrosion resistance is required. The weld deposit can sustain working temperatures up to 450° C. and will offer scale resistance up to 950° C. Preheating is recommended at 250° C and stress relieving at 800° C in case it is allowed for the base metal

PROPERTIES High deposition rate and excellent weldability on DC+.

CLASSIFICATION

AWS	A 5.1: E 430-15
EN ISO	3581-A: E 17 R 52
DIN: W.Nr.	1.4015
DIN	E 4015 HL-Kb

SUITABLE FOR 1.4057, 1.4740, 1.4742, 1.4059, 1.4741, Steam valves, pumps etc

APPROVALS CE approved

WELDING POSITIONS:



WELD DEPOSIT WEIGHT % (TYPICAL)

C	Mn	Si	Cr	Ni	Mo
<0.10	<0.7	-	16-18	<0.5	0.8-1.2

MECHANICAL PROPERTIES

Heat Treatment	Rp0,2 (N/mm ²)	Rm (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V			Hardness HB
				-20°C	-40°C	-60°C	
AW	-	-	-	-	-	-	240 HB 30
SR	340	540	20	-	-	-	150 HB 30

AW = As welded / SR = Stress relieved 800°C / 1 hr

WELDING PARAMETERS PACKING

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A)	kg / can	kg / 6pack	kg / 1000
2.5	300	60-90			
3.2	350	80-110			
4.0	350	100-150			

REDRYING TEMPERATURE 300°C/2hr

RECOVERY 150%