

## 4115 HL

**CATEGORY** SMAW Stick Electrodes

**TYPE** High recovery, corrosion resistant stainless steel stick electrode

**APPLICATIONS** Hardfacing shafts from stainless steel parts, molt repairs, rebuilding pump parts etc. Suitable for plating and joining equal and similar ferritic Cr-steels and cast steels. Proper weldings are subject to the recommended heat treatment. This alloy is specially suitable for sealing surfaces on water-, steam and gas-valves, especially for sulphuric gases. The deposit is resistant to seawater, thin acids and scale resistant in air and oxidizing gases up to 950°C . The weld deposit can be tempered.

**PROPERTIES** High deposition rate and excellent weldability on DC +. Stainless steel alloy for joining and cladding 17% Chromium alloys and cladding components where heat and corrosion resistance simmlar to AISI 304 is required. The weld deposit can sustain working temperatures up to 450° C. and will offer a high hardness and wear resistance.

**CLASSIFICATION**

AWS	A 5.4: ~E 430HMo-26
EN ISO	3581-A: EZ 17 Mo R 52
DIN: W.Nr.	1.4115
DIN	8556: E 17 Mo B20+

**SUITABLE FOR** 1.4122 (G)X35CrMo17, 1.4313, 1.4000, 1.4001, 1.4002, Cast steels

**WELDING POSITIONS:**



**WELD DEPOSIT WEIGHT % (TYPICAL)**

C	Mn	Si	Cr	Ni	Mo
0.18	0.7	0.4	16-17	0.15	0.8-1.5

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HRc / HB
				-20°C	-40°C	-60°C	
AW							43 HRc
PWHT 720°C/2hr	500	700	15				200 HB

AW: as welded / PWHT: post weld heat treatment

**WELDING PARAMETERS PACKING**

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A)	kg / can	kg / 6pack	kg / 1000
2.5	300	80-120			
3.2	350	100-160			
4.0	450	160-220			

**REDRYING TEMPERATURE** 300°C/2hr