Stanvac® INTERNATIONAL

Product Data Sheet

STAVINOX 430-15

MMA Electrodes
Stainless & Heat Resistant Steels

Classification ***AWS A*5.4:** E 430-15 **EN ISO 3581:** E 17 B 22

Description: Rutile coated high performance electrode for welding of stainless, heat resistant and cold tough steels and cast steel types, on identical ferrite and similar heat treatable steels/cast steel types, 15-17 % Cr (AISI 430). Suitable for surfacing and plating on scaling surfaces water, steam and gas fillings made from unalloyed/low alloyed/steels cast steel. This electrode is ideally suitable for surfacing on rails subject to wear and can be used for the refurbishment and repair up to 475ºC.

Materials:

Material	Steel
1.4057	X 17 CrNi 16-2
1.4059	G X 22 Cr Ni 17
1.4510	X3 CrTi 17
----	AISI 430/430Ti

All weld metal mechanical properties (typical)

Heat Treatment	Yield Strength N/mm2	Tensile Strength N/mm2	Elongation A5 (%)	Hardness
750°C /2h	≥350	≥550	≥20	38-40 HRc

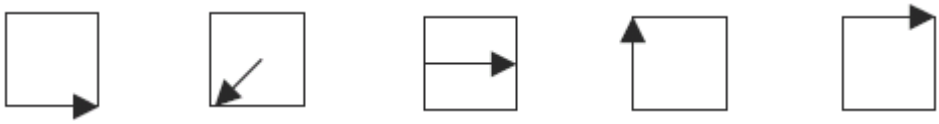
Welding recommendations:

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Storage and redrying

Keep dry and avoid condensation.
Re-dry at 300-350°C /1 hour, 3 times max.

Welding positions:



Welding current

Dia./Length	Amperage
mm	A
2.50 /350	50 - 70
3.15 /350	80 - 110
4.00 /350	130 - 150

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