

ES HF 40

SMAW

ESWECO
The Art of Welding

Type Low hydrogen, sodium

EDCrNi-B-15

Description

ES HF 40 Mainly be used for surfacing sealing surface of high pressure valves that work temperature below 600°C. Depend on elements of Si, Mo, Nb, Ni, V to intensify the deposited metal to be a kind of austenite matrix which with few ferrites and it has higher high temperature hardness, good heat stability and it has good performance of high temperature abrasion-resisting, heat fatigue resistance and erosion resistance. The deposited metal will be the longer of the aging time the better the abrasion-resisting and more hardness.

Notice: * The rod should be redrying at 250 °C for 1 hour before use.

To guarantee hardness, the deposited metal should not be lower than 5 mm after machining & should not be too high to avoid cracks.

Current

DC+



Classifications

GB/T 984 EDCrNi-B-15

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Nb	Other
0.14	4.25	1.4	17.28	10.3	4.98	0.85	1.2

Typical mech. Properties all weld metal

Hardness, HRC 37-47

Welding parameters

Diameter,mm	Length,mm	Welding current, A	Arc voltage,V
3.2	300	80-110	25
4.0	350	120-160	27
5.0	350	170-200	28