

# CITOCHROM 13.4

## MMA Electrodes Stainless and Heat resistant steels

Basic coated MMA electrode for welding stainless martensitic chromium-nickel steels or cast steels. For wall thicknesses over 10mm preheating to max. 150 °C is recommended. After welding, tempering or normalizing + tempering is required. Vacuum packaging.

Classification	
AWS	A5.4: E410NiMo-15
EN	1600: E 13 4 B 22

Approvals	Grades

### Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
≤ 0.06	0.90	0.40	≤ 0.025	≤ 0.020	11.50	4.50	0.50	-	-	-	-

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation A5 (%)	Impact Energy ISO - V (J) - 60 °C	Hardness
610°Cx1h/air or 610°Cx5h	≥ 600	≥ 850	≥ 15	≥ 50	-

### Materials

1.4313 (X4CrNi13-4); 1.4413 (X3CrNiMo13-4)

1.4407 (G-X5CrNiMo13-4); 1.4414 (G-X4CrNiMo13-4)

### Storage and redrying

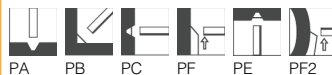
Keep dry and avoid condensation.

Re-drying not generally required.

If necessary: 280-300 °C for 1 hour, 5 times max.

### Current condition and welding position

DC+



### Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,5	300	65-95	18,5	11,1
3,2	350	85-130	38,4	23,0
4,0	350	120-180	53,2	31,9
5,0	350	190-240	87,5	52,5