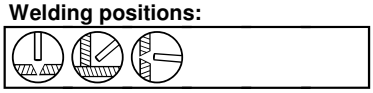
Cromacore MXA 135N

FCAW - Flux cored arc welding
Stainless Steel

Date:	1999-03-22
Revision:	1

Description:
Cromacore MXA 135N is a metal-cored wire designed for welding similar composition 13%Cr, 5%Ni-martensitic stainless steels.These high strength steels offer improved resistance to corrosion, cavitation and sulphide-induced stress corrosion cracking compered to the straight 12%Cr, (type 410), steels. For heavier section material a preheat and interpass temperature of 150°C is recommended.

Welding positions:



Welding current:
DC +

Deposition efficiency:
96%

Shielding gas:
80% Ar + 20% CO2, 22-25 l/min.

Stick-out:
15-25 mm

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min						11.5	4.6
Typical	0.015	0.6	0.30	0.024	0.007	12.5	5.0
Max	0.04	1.0	1.0	0.030	0.025	13.5	5.4

	Mo	Cu
Min		
Typical	0.027	0.06
Max	0.5	0.5

Mechanical properties

	Specified	Typical	PWHT Typical
Yield strength, Rp0.2%:	≥ 540 MPa		790 MPa
Tensile Strength, Rm:	≥ 740 MPa		850 MPa
Elongation, A5	≥ 17%		21%
Impact energy, CV:	0°C•> 47 J		0°C•60 J

Classification:
ISO 17633-A ~T 13 4 M M 3

Approvals:

Product data:

Diam.mm	Product code	Spool weight
1,2	95842012	12,5 kg PSP

Note

Specified mechanical properties are after PWHT, 580-600°Cx10 h.