



D&H 444L

CODIFICATION : AWS : SFA 5.4 E410NiMo-16

CHARACTERISTICS AND APPLICATIONS :

D&H 444L is a special purpose electrode depositing 12Cr - 4.6Ni - 0.5Mo weld metal, which has excellent resistance to corrosion, erosion, pitting and impact. Ideally suited for joining of similar composition materials, groove welding and surfacing applications. Typical applications include surfacing of high pressure valves, turbine blades, valve seats, repairs of runners, pulp and paper plant equipment, etc.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

Element	: C	Mn	Si	Cr	Ni	Mo
Percent	: 0.05	0.60	0.50	12.0	4.60	0.50

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL (PWHT : 610°C FOR 1 HR)

UTS (MPa)	Elongation (L=4d)%	Hardness (VPN)
782	17.0	325-360

CURRENT AND PACKING DATA : AC / DC(+)

Size (mm)	: 5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	: 150-190	110-150	80-100	60-80
Weight/Cartron (kgs)	: 2.5	2.5	2.5	2.5

PRECAUTIONS :

1. Ensure the electrodes are dry. In case of moisture pick-up, redry the electrodes at 200-250°C for one hour.
2. Use short arc and minimum heat input.

NOTE :D&H 444L-15 Conforming to **AWS : E410NiMo-15** is also available.