



MODI 430 Ni Mo STAINLESS STEEL ELECTRODE

CHARACTERISTICS : MODI 430 NiMo is a special purpose electrode characterised by excellent operating features, evenly uniform weld beads and easy slag detachibility.

APPLICATIONS : MODI 430 NiMo is ideally suited for surfacing of components subjected to corrosion, erosion, abrasion, combined with moderate degree of impact. It can be used for applications on ferritic as well austenitic steels for surfacing of wide variety of machine parts and components. The electrode can also be used for joining applications. Some of the typical applications include:

- * Hardsurfacing of high pressure valves and valves seats.
- * Repair of runners and rebuilding of turbines blades in hydro-electric projects.
- * Hard surfacing of steel parts subject to corrosion, erosion and wear.
- * Rebuilding of gas and steam turbine.

RECOMMENDATIONS : Re-dry the electrodes at 250°C for one hour. The base metal should be cleaned before commencement of welding. Thick sections should be preheated between 150°C and 250°C. This temperature should be maintained until the welding is completed.

CHEMICAL ANALYSIS OF WELD-METAL(%) :	C	Mn	Si	Cr	Ni
	0.10 max	0.85-1.20	1.0 max	15.0-18.0	4.0-5.0
	Mo	Cu	S	P	
	0.85-1.20	0.75 max	0.03 max	0.04 max	

HARDNESS : On two layers : 250 to 300 BHN (Depending upon base material)

CURRENT CONDITIONS : USE AC OR DC (+)

Size (mm)	2.5x350	3.15x350	4.0x350	5.0x350
Amps	60-80	80-110	110-140	150-180



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