

EXCALIBUR® E410NIMO-16

Stainless • AWS E410NIMO-16



KEY FEATURES

- This electrode can be used to overlay mild and low alloy steels
- Preheat and inter-pass temperatures greater than 300°F (150°C) are recommended during welding
- Post-weld heat treatment should not exceed 1150°F (620°C) as higher temperatures may result in hardening

CONFORMANCES

AWS A5.4/A5.4M: 2012

E410NiMo-16

ASME SFA A5.4:

E410NiMo-16

TYPICAL APPLICATIONS

- Turbines
- Valve Bodies
- High Pressure Piping
- Offshore
- Power Generation
- Welding CAGNM
- Stainless Steel

WELDING POSITIONS

All, except vertical down

DIAMETERS / PACKAGING

Diameter		Length		10 lb (4.5 kg) Easy Open Can
in	(mm)	in	(mm)	30 lb (13.6 kg) Master Carton
1/8	(3.2)	14	(355)	ED035015
5/32	(4.0)	14	(355)	ED035016
3/16	(4.8)	14	(355)	ED035018

DEPOSIT COMPOSITION(1)

	%C	%Cr	%Ni	%Mo	%Mn
Requirements					
AWS E410NiMo-16	0.06 max	11.0 - 12.5	4.0 - 5.0	0.40 - 0.70	1.0 max
Typical Results(2)	0.02	11.7	4.6	0.58	0.5
	%Si	%P	%S	%Cu	FN
Requirements					
AWS E410NiMo-16	0.90 max	0.04 max	0.03 max	0.75 max	Not Required <input type="checkbox"/>
Typical Results(2)	0.37	0.02	0.01	0.07	-

TYPICAL OPERATING PROCEDURES

Polarity(5)	Current (Amps)			
	3/32 in (2.4 mm)	1/8 in (3.2 mm)	5/32 in (4.0 mm)	3/16 in (4.8 mm)
AWS E410NiMo-16 DC+/AC	40 - 80	75-110	95 - 150	130 - 200