

410 NiMo

CATEGORY GMAW-GTAW Solid wires

TYPE Solid stainless steel wire for joining and cladding.

APPLICATIONS Solid welding wire of the 12% Cr, 4.5% Ni, 0.5% Mo type. 410NiMo is used for welding similar martensitic and martensitic-ferritic steels in different applications, such as hydro turbines.

CLASSIFICATION

AWS	A 5.9: ER 410 NiMo
EN ISO	14343-A: G 13 4
DIN: W.Nr.	1.4351
DIN	8556: SG-X3CrNi 13 4

SUITABLE FOR Water and steam turbine parts of the same kind, thermoshock and high heat resistant. 1.4313, 1.4002, (G)X5CrNi(Mo) 13 4, X6CrAl 13, Grade CA 6 NM.

APPROVALS CE approved

WELDING POSITIONS:



WELD DEPOSIT WEIGHT % (TYPICAL)

C	Mn	Si	Cr	Ni	Mo
0.03	0.7	0.8	13	4.7	0.5

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc / HB
				20°C	-40°C	-60°C	
AW PWHT 600°C/8hr	>680	>800	>15	50			38 HRc 250 (HB30)

AW: as welded / PWHT: post weld heat treatment

WELDING PARAMETERS PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A) DC+	spool type	kg / spool / Drum	kg / pallet
1.0	16-24	80-190	K-300 / Drum	15 / 250	1080 / 1000
1.2	20-28	180-280	K-300 / Drum	15 / 250	1080 / 1000
1.6	24-28	230-350	K-300 / Drum	15 / 250	1080 / 1000

TIG WELDING 1000 mm cut lengths are available from 1,6 till 3,2 mm in 5 kg tubes