

## 410 NiMo TIG

**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: W 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 <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				20°C	-40°C	-60°C	
AW							38 HRc
PWHT 600°C/8hr	>680	>800	>15	50			250 (HB30)

AW: as welded / PWHT: post weld heat treatment welding parameters packing

**WELDING PARAMETERS PACKING**

D (mm)	Welding Parameters		Current (A) DC-	Packing kg
	Length (mm)			
1.6	1000		50 - 80	5
2.0	1000		70 - 110	5
2.4	1000		110 - 180	5
3.2	1000		150 - 250	5