

OA 410 NiMo

CATEGORY FCAW Flux-Cored

TYPE Self-Shielded fluxcored CrNiMo wire

APPLICATIONS Bridge bearings, sealing surfaces, corrosion, slide ring sealing, centrifuge, continuous casting rolls

PROPERTIES The corrosion resistant deposit with a medium hardness is resistant against impact wear as well as permanent stress by heat influence, metal wear and high surface pressure

CLASSIFICATION

AWS	A 5.22: 410NiMo
EN ISO	14700: ~410NiMo
DIN: W.Nr.	1.4351
DIN	8555:

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.

WELDING POSITIONS:



FILLER METAL ANALYSIS % (TYPICAL VALUES)

C	Mn	Si	Cr	Ni	Mo	Fe
0.05	1.0	0.9	14	4.5	0.75	Rem

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRC
				-20°C	-40°C	-60°C	
AW							38-41

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet
1,2	18-26	120-220	S-300	15	1080
1.6	20-26	100-200	S-300	15	1080
2.0	24-28	100-260	B-415	25	900
2.4	26-29	240-380	B-415	25	900

REDRYING TEMPERATURE 150°C/24hr