

## 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 <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 / 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