



MIGINOX 410NiMo

GMAW STAINLESS STEEL

AWS A/SFA 5.9 ER410NiMo

CLASSIFICATION:

EN ISO 14343-A
G 13 4

IS 5856
ES 13.4

KEY FEATURES:

- 13Cr/4Ni type stainless steel wire
- High strength combined with excellent toughness and cracking resistance
- Preheat and PWHT recommended
- Martensitic type alloy resistant to corrosion, erosion, pitting and impact
- Smooth operating characteristics
- Radiographic quality welds

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding of ASTM CA 6NM casting or similar grades as well as light gauge 410, 410S and 405 base metals
- Surfacing of turbine blades, high pressure valves
- Welding of extra low carbon castings and forgings of similar composition and surfacing applications
- Repair of runners, valve seats, pulp and paper plant equipment



TYPICAL CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt %:

C	Mn	Si	Cr	Ni	Mo
0.02	0.35	0.5	12.1	4.4	0.45

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Typical	PWHT: 600°C for 1 hr	800	17

PARAMETERS - PACKING DATA:

Ø, mm	Kg/Spool		All Positions
1.2	12.5	 DCEP STORAGE / HANDLING : Keep dry and follow handling instructions mentioned on the box	
1.6	12.5		

Shielding Gas	Gas Flow Rate, LPM
98Ar/2O ₂ or Ar/1-5CO ₂	15-25