



MCAW STAINLESS STEEL
MIGINOX MC 410NiMo

410NiMo TYPE GAS SHIELDED METAL CORED WIRE



CLASSIFICATION : AWS A/SFA 5.22 EN ISO 17633-A

EC410NiMo T 13 4 M M13/M21 3

KEY FEATURES :

- Gas shielded metal cored wire
- Typical 12Cr-4.5Ni-0.5Mo deposit
- High strength combined with excellent toughness and cracking resistance
- Martensitic type alloy resistant to corrosion, erosion, pitting and impact
- Preheat and PWHT recommended
- Stable smooth arc, no spatter
- Radiographic weld quality

WELDING POSITION :



DCEP

Shielding Gas	Gas Flow Rate, LPM	Stickout, mm
80Ar/20CO ₂ or 98Ar/2O ₂	15-25	10-20

TYPICAL APPLICATIONS :

- Welding of ASTM CA 6NM casting or similar materials
- Welding of extra low carbon castings and forgings of similar composition and surfacing applications
- Surfacing of turbine blades, high pressure valves
- Repair of runners, valve seats, pulp and paper plant equipment

STORAGE / HANDLING :

Keep dry and follow handling instructions mentioned on the box

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt% :

	C	Mn	Si	Cr	Ni	Mo	S	P
Specification	0.06 max	0.60 max	0.50 max	11.0-12.5	4.0-5.0	0.4-0.7	0.03 max	0.03 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	EL%
Specification	PWHT:610°C for 1 hr	760 min	15 min

PARAMETERS - PACKING DATA :

Ø, mm	Voltage, V	Amperage, A	Kg/Spool
1.2	24 – 32	150 - 280	12.5/15
1.6	25 – 33	180 - 310	12.5/15