



# MIGINOX FC 410NiMo

AWS A/SFA 5.22 E410NiMoT1-1/4

FCAW STAINLESS STEEL

### CLASSIFICATION:

EN ISO 17633-A

T 13 4 P C1 2

T 13 4 P M21 2

### KEY FEATURES:

- Rutile based gas shielded stainless steel FCAW wire
- Typical 11.5Cr-4.5Ni-0.5Mo stainless steel deposit
- High strength combined with excellent toughness and cracking resistance
- Preheat and PWHT recommended
- Stable arc, low spatter and easy slag removal
- Radiographic weld quality
- Martensitic type alloy resistant to corrosion, erosion, pitting and impact

### APPROVALS: CE

### 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

### CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:


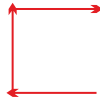
C	Mn	Si	Cr	Ni	Mo
0.06 max	1.0 max	1.0 max	11.0-12.5	4.0-5.0	0.40-0.70

### MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Specification	PWHT:600°C for 1 hr	760 min	15 min

With mixed gas chemical composition and mechanical properties will be higher.

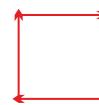
### PARAMETERS - PACKING DATA:

Ø, mm	Kg/Spool	
1.2	12.5	 <b>DCEP</b> All Positions, Except Vertical Down: 
1.6	12.5	



DCEP

All Positions, Except Vertical Down:



### STORAGE / HANDLING :

Keep dry and follow handling instructions mentioned on the box

Shielding Gas	Gas Flow Rate, LPM
CO <sub>2</sub>	15-20
80Ar+20CO <sub>2</sub>	18-25