

❖ Product Description

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| I. 13Cr/4Ni type stainless steel wire | III. Resistant to corrosion, erosion, pitting and impact |
| II. Has high strength combined with excellent toughness and cracking resistance | IV. The operating is smooth |
| | V. Radiographic weld quality |

❖ Range of Application

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| I. For welding ASTM 6NM casting or similar grades as well as light gauges | III. Welding of extra low carbon casting and forgings of similar composition and surfacing applications |
| II. Surfacing of turbine blades and high pressure valves | IV. Repair of runners, valve seats, pulp and paper plant equipment |

❖ Classification

- AWS/SFA 5.9 ER410-NiMo

❖ % Chemical Composition

Type of Wire		C	Mn	S	Si	Cr	Cu	Mo	P	Ni
ER410-NiMo	Min	-	-	-	-	11.0	-	0.4	-	4.0
	Max	0.06	0.6	0.03	0.5	12.5	0.75	0.7	0.03	5.0

❖ Mechanical Properties of all weld metal

Condition	UTS, MPa (Min)	YS, MPa (Min)	% Elongation	Charphy "v" Notch Impact @ -30°C
As Welded	760	-	15	-

❖ Wire Size & Welding Position

- Diameter in mm- 0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60
- Weld Position- All position

❖ Current & Gas Flow

- DCEP; 15-22lit/min

❖ Packaging

Sizes Available in mm	0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60								
Packing Code	A	B	C	D	E	F	G	H	I
Packing Available	SD 100	SD200	SD270	SD 270	SD300	SD300	100kg Drum Pack	250kg Drum Pack	350kg Drum Pack
Net Weight of Wire	1KG	2KG	12.5KG	15KG	12.5KG	15KG	100KG	250KG	350KG

Special Notes: -

- (1) All the value above mentioned are typical values.
- (2) Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

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