



410NiMo-15 DC+

STAINLESS STEEL

DESCRIPTION

Basic coated electrode for repair and construction welding of martensitic CrNi steels of similar composition. These steels / castings are used for hydraulic turbines, pumps, valve bodies, compressor parts... Stable arc, easy slag removal, regular weld beads.

CLASSIFICATION

AWS A 5.4 : E410NiMo-15 EN 1600 : E 13 4 B 42 ISO 3581-A : E 13 4 B 42

BASE MATERIALS : 410, 410S, 405, CA6-NM

PROCEDURE

Rebake electrodes 2h at 300°C. Guide electrodes with a slight declination, weld with a short arc. Preheat base material to 100-150°C and keep this temperature during welding. Cool down to room temperature and perform the PWHT.

MECHANICAL PROPERTIES*

Tensile strength: > 120 000 psi (> 830 MPa)
 Yield strength: > 90 500 psi (> 630 MPa)
 Elongation: > 15 %
 Impact (Charpy V): > 50 J at +20°C

* after PWHT 580°C/8h

TYPICAL WELD METAL COMPOSITION (%)

C	Mn	Si	Cr	Ni	Mo	Fe
0.04	0.60	0.30	12.0	4.2	0.5	Rem

WELDING PARAMETERS

Diameter:	4.0 mm (5/32")	3.2 mm (1/8")	2.5 mm (3/32")
Amperage:	160 A	120 A	90 A

WELDING POSITIONS



1G/PA 2F/PB 2G/PC 3G/PF 4G/PE

Rév. :7_01

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