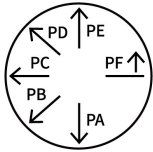


SW-410NiMo Cored

Classification

AWS AWS A5.22/ ASME SFA-5.22 E410NiMoT1-1/-4
JIS Z 3323 TS410NiMo-FB1
EN ISO 17633-A-T 13 4 P M21/C1 2

Welding Positions



Features

- Good performance in all positions

Polarity

DC +

Application Areas

- Martensite Stainless steels (ASTM, CA6NM)
- Hardfacing of continuos casting rolls, valve seat, etc
- Power plant

Shielding Gas

100% CO2
Ar+20~25% CO2

Typical Chemical Composition of All-Weld Metal (wt%)

Shielding Gas	C	Si	Mn	P	S	Ni	Cr	Mo
100% CO2	0.03	0.4	0.5	0.011	0.010	4.3	12.2	0.51
Ar + 20% CO2	0.04	0.4	0.6	0.010	0.011	4.5	12.2	0.53

Typical Mechanical Properties of All-Weld Metal

Shielding Gas	Tensile Strength MPa(ksi)	Elongation (%)
100% CO2	890 (129)	20
Ar + 20% CO2	900 (132)	21

Diameter / Welding Parameters / Packaging

Wire Diameter mm(in)	Current (A)	Packaging
1.6(1/16)	160~220	Spool 5kg (11lbs), 12.5kg (28lbs), 15kg (33lbs), 20kg (44lbs) Drum 100kg (221lbs), 200kg (441lbs), 250kg (551lbs)

SMW

GMAW

GTAW

FCAW

Metal-cored Wire

SAW Wire

SAW Flux