

SW-410NiMo Cored

TYPE : Rutile

AWS A5.22 /ASME SFA5.22 E410NiMoT-1-1/4
JIS Z3323 TS410NiMo-FB1
EN ISO 17633-A-T 13 4 P M/C 2

Applications

All position welding of martensitic stainless steels, hardfacing of continuous casting rolls, valve seats, etc.

Characteristics on Usage

SW-410NiMo Cored is a flux cored wire for martensitic stainless steel like CA6NM. SW-410NiMo cored is a titania type flux cored wire for all position welding with CO₂ & Mixed gas. As deposition rate is higher than solid wire and MMA electrode, highly efficient welding can be performed. Arc stability is excellent, so spatter loss is low and slag covering is uniform with good removability.

Notes on Usage

- ① Proper preheating (50~150°C) (122~302°F) and interpass temperature must be adopted in order to release hydrogen which may cause crack in weld metal.
- ② Both 100% CO₂ and mixed (Ar+20~25% CO₂) gas are useful.

Welding Position



1G (PA) 2F (PB) 3G (PF) 4G (PE)

Current

DC +

Shielding Gas

CO₂/Ar+20~25%CO₂

Typical Chemical Composition of All-Weld Metal (%) (Shielding Gas: 100% CO₂)

C	Si	Mn	P	S	Cr	Ni	Mo
0.03	0.41	0.46	0.011	0.010	12.2	4.30	0.51

Typical Mechanical Properties of All-Weld Metal (Shielding Gas: 100% CO₂)

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)	Hardness (HRc)	PWHT
700 (102,000)	850 (123,000)	17	0 (32)	50 (37)	As weld:37 PWHT :27	600° C × 1Hr,AC
710 (103,000)	890 (129,000)	20	0 (32)	50 (37)	As weld:37 PWHT :26	590° C × 3Hr,FC

Approval

I Packing(Including Ball Pac)

Dia. (mm)	1.2	1.6	Spool(kg)	12.5	15
(in)	.045	1/16	(lbs)	28	33

Sizes Available and Recommended Currents (Amp.)

Size mm(in)	1.2 (.045)	1.6 (1/16)
F&HF		200~350
V-up,OH		170~260