

CODIFICATION: AWS/SFA 5.9: ER410NiMo

CHARACTERISTICS AND APPLICATIONS:

FW 410NiMo is a solid wire for TIG welding, available in bright finish, gives smooth flow, stable arc and spatter free under optimum welding conditions. It gives radiographic quality weld deposit. Weld metal possesses excellent resistance to corrosion, pitting, abrasion, and impact. Welding for surfacing of ASTM CA 6 NM castings and similar composition subjected to wear by corrosion, erosion, abrasion combined with impact. Ideally suitable for welding of guide vanes and runners, hard facing of valve seats, turbine blades in hydro power plants, pulp and paper machinery, rebuilding of gas, steam turbines, etc.

TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

Element	C	Mn	Si	S	P	Cr	Ni	Mo
Percent	0.05	0.50	0.40	0.025	0.025	11.5	4.5	0.50

**TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:
(PWHT: 600°C for one Hour, Air Cool)**

UTS (MPa)	Elongation (L=4d) %	Hardness (VPN)
800	17.0	325-360

SHIELDING GAS : Argon

CURRENT CONDITIONS : DCEN

WELDING POSITION : H, F, VU, OH

PACKING:

STANDARD SIZE	Diameter 1.6 mm, 2.0 mm, 2.5 mm & 3.2 mm in cut lengths of 1000 mm each.
QUANTITY	5 kgs wire put in an air-tight polythene bag and finally packed in a plastic container. Identification – AWS code is punched on both the sides of wire.

An ISO 9001: 2008 certified company

D & H Sécheron Electrodes Pvt. Ltd.

44-46, Industrial Estate, Kila Maidan, Indore-452 006, India, Ph: 0731 2412331-2, 4229222 Fax: 0731 4229260
e-mail: info@dnhsecheron.net Website: www.dnhsecheron.com