

MIGINOX FC 410NiMo

AWS A/SFA 5.22 E410NiMoT1-4

FCAW STAINLESS STEEL

CLASSIFICATION:

EN ISO 17633-A
T 13 4 P C1 2
T 13 4 P M21 2

KEY FEATURES:

- Rutile based gas shielded stainless steel FCW wire recommended
- Typical 11.5Cr-4.5Ni-0.5Mo stainless steel deposit
- High strength combined with excellent toughness and cracking resistance
- Preheat and PWHT
- Stable arc, low spatter and easy slag removal
- Radiographic weld quality
- Martensitic type alloy resistant to corrosion, erosion, pitting and impact

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding of ASTM CA 6NM casting or similar materials
- Welding of extra low carbon castings and forgings of similar composition and surfacing applications
- Surfacing of turbine blades, high pressure valves
- Repair of runners, valve seats, pulp and paper plant equipment


CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Cr	Ni	Mo
0.06 max	1.0 max	1.0 max	11.0-12.5	4.0-5.0	0.40-0.70


MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Specification	PWHT:600°C for 1 hr	760 min	15 min

PARAMETERS - PACKING DATA:

∅, mm	Kg/Spool	
1.2	12.5	 DCEP STORAGE / HANDLING : Keep dry and follow handling instructions mentioned on the box
1.6	12.5	

All Positions, Except Vertical Down:



Shielding Gas	Gas Flow Rate, LPM
CO ₂	15-20
80Ar+20CO ₂	18-25

It can work with CO₂ sheilding gas.