

## Select 410NiMo-C

### Description:

**Select 410NiMo-C** is a composite metal cored electrode for use with external shielding gas. It is designed to weld ASTM CA6NM castings and certain 410 alloys. This electrode may be used for welding in the flat and horizontal positions. The preferred shielding gas is argon with 2% oxygen.

### Classification:

- EC410NiMo per AWS A5.22
- EC410NiMo per AWS A5.9:2006

### Characteristics:

**Select 410NiMo-C** operates with a smooth, spray arc transfer. It produces little or no slag and virtually no spatter, minimizing cleanup. It offers higher deposition rates and more controlled penetration than the equivalent solid electrode. As a result it operates at higher travel speeds and handles poor fit-up.

### Typical Mechanical Properties (Ar-2%O<sub>2</sub>):

	<u>SR 1 Hr. at 1125° F</u>
Ultimate Tensile Strength (psi)	126,500
Yield Strength (psi)	113,400
Percent Elongation	18

### Typical Weld Deposit Chemistry:

<u>Shielding Gas</u>	<u>C</u>	<u>Mo</u>	<u>Cr</u>	<u>Mn</u>	<u>Ni</u>	<u>Si</u>
98Ar2CO <sub>2</sub>	0.01	0.50	12.0	0.5	4.3	0.4

### Typical Welding Parameters (Ar-2%O<sub>2</sub>)\*:

<u>Diam. (in.)</u>	<u>Amperage</u>	<u>Range</u>		<u>Amperage</u>	<u>Optimum</u>	
		<u>WFS</u>	<u>Voltage</u>		<u>WFS</u>	<u>Voltage</u>
.045	255	410	25-26	180-330	240-600	22-28
1/16	350	300	26	230-520	160-500	22-31

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Notice: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. Thus the results are not guarantees for use in the field. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.