

Select 410NiMo-AP

Stainless Steel / Gas Shielded / Flux Cored

PRODUCT DATA SHEET

FEATURES

- Modified to contain less chromium (Cr) and more nickel (Ni) to eliminate ferrite in the microstructure that improves mechanical properties.
- Designed for welding in all positions. Well washed beads can be achieved when manipulating the puddle in both 100% CO₂ or 75-80% Ar/balance CO₂ shielding gas
- Postweld heat treatment temperatures need to be closely monitored with this alloy type, as higher temperatures, i.e. 1150F, may result in rehardening due to untampered martensite in the microstructure after cooling to room temperature.
- Application for this alloy is generally used to weld C6NM castings or similar materials found in the power generation industry, especially with turbine blades and vanes.

CONFORMANCES

AWS A5.22

E410NiMoT1-1

E410NiMoT1-4

ASME SFA 5.22

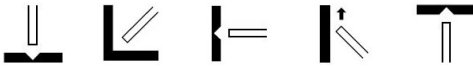
E410NiMoT1-1

E410NiMoT1-4

DIAMETERS (in [mm])

0.045 (1.2), 1/16 (1.6)

POSITIONS



SHIELDING GAS

75-80% Ar + Balance CO₂, 100% CO₂

Flow Rate: 40 - 50 CFH

POLARITY

Direct Current Electrode Positive (DCEP)

TYPICAL WELD DEPOSIT CHEMISTRY [WT%]

Shielding Gas	C	Cr	Cu	Mn	Mo	Ni	P	S	Si
100%CO ₂	0.02	11.80	0.03	0.31	0.50	4.55	0.011	0.006	0.36
75%Ar / 25%CO ₂	0.02	12.00	0.03	0.33	0.52	4.61	0.012	0.007	0.41

Bismuth is not intentionally added and levels are not known to be greater than 0.002 (WT%)

TYPICAL MECHANICAL PROPERTIES

Shielding Gas	Tensile Strength ksi (MPa)	Yield Strength ksi (MPa)	Elongation (%)	Weld Condition	PWHT Temp
100%CO ₂	130 (897)	117 (807)	19	PWHT	1125°F for 1 hr
75%Ar / 25%CO ₂	132 (910)	118 (814)	16	PWHT	1125°F for 1 hr



Notice: Be sure to follow all your employers safety practices, policies and procedures when using this product. Refer to CSA W117.2 and ANSI Z49.1 Safety in Welding, Cutting and Allied Processes for further information and the manufactures SDS sheet. 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. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. 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.

RECOMMENDED WELDING PARAMETERS **

Diameter in (mm)	Shielding Gas	Position	WFS* in/min (m/min)	Amps	Volts	CTWD* in (mm)
0.045 (1.2 mm)	100% CO2	All Positions	200 (5.1)	145	23	1/2 - 5/8 (13 - 16)
		All Positions	235 (6.0)	160	24	1/2 - 5/8 (13 - 16)
		All Positions	300 (7.6)	185	26	1/2 - 5/8 (13 - 16)
		Flat & Horizontal	375 (9.5)	215	27	5/8 - 3/4 (16 - 19)
		Flat & Horizontal	440 (11.2)	235	29	5/8 - 3/4 (16 - 19)
1/16 (1.6 mm)	100% CO2	All Positions	125 (3.2)	165	23	5/8 - 3/4 (16 - 19)
		All Positions	150 (3.8)	195	24	5/8 - 3/4 (16 - 19)
		All Positions	185 (4.7)	225	26	5/8 - 3/4 (16 - 19)
		Flat & Horizontal	265 (6.7)	280	27	3/4 - 1 (19 - 25)
		Flat & Horizontal	325 (8.3)	320	29	3/4 - 1 (19 - 25)

* WFS = Wire Feed Speed, CTWD = Contact Tip To Work Distance

**The parameters listed are recommended starting points of operation and the ranges for amperage, wfs, and voltage could be extended based on fitness for application. For products with "all-position" capability, as determined and listed in classification, the position recommendation can be determined based on operator skill and material thickness and isn't limited to the listing.

For 75-80%Ar-Balance CO2 shielding gas, decrease voltage by 1 to 1.5 volts

PACKAGING (lbs (kgs))

33 (15) Spools, 60 (27.2) Coils, 500 (226.8) Round Drum, 800 (362.9) Hex Drum, 900 (408.2) Hex Drum

*Some packaging options may not be available depending on diameter and product. Special package options may be available upon request.

STORAGE AND HANDLING

All products should be stored in original packaging, in dry conditions and handled with care. For more information refer to our website.



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