

## Classifications

<b>AWS A5.9</b>	<b>EN ISO 14343-A</b>	<b>YB/T 5092</b>
ER410NiMo	G 13 4	H 06 Cr 12 Ni 4 Mo

## Characteristics and typical fields of application

- GMAW solid wire of type W 13 4 designed for numerous applications.
- For the fabrication and repair welding of hydro turbine components made of soft martensitic 13%Cr 4%Ni alloyed steels and cast steels.
- Very good welding characteristics, high resistance to cracking.

## Base materials

1.4317 GX4CrNi13-4, 1.4313 X3CrNiMo13-4, 1.4407 GX5CrNiMo13-4, 1.4414 GX4CrNiMo13-4, ACI Grade CA 6 NM.

## Typical analysis of all-weld metal

C	Si	Mn	P	S	Cr	Ni	Nb			
0.02	0.45	0.5	0.010	0.010	12.4	4.7	0.5			

## Mechanical properties of all-weld metal – typical values (min. values)

Condition	Yield strength R <sub>p0.2</sub>	Tensile strength R <sub>m</sub>	Elongation A (L <sub>0</sub> =5d <sub>0</sub> )	Impact work ISO-V KV J	
	MPa	MPa	%	+20°C	-20°C
620°C/2h	890(≥ 680)	960 (≥800)	17 (≥ 15)	80(≥47)	≥32

## Operating data

	<b>Polarity:</b>	<b>Shielding gas:</b>	<b>Dimensions</b>
	DC +	(ISO 14175)	(mm)
		M12	1.0
			1.2
			1.6

## Approvals

CE