



FCW 410NiMo

Flux cored Wire

Classification

AWS A5.22 E410NiMoT1-1/4 ISO 17633-A T 13 4 P M2
ISO 17633-B TS410NiMo-FM1

Characteristics

Rutile Flux cored wire to weld in all positions. It is used for cladding & joining of CA-6NM, 409,410,410S & 405 type of steels. A post weld heat treatment at 580 – 620°C is advised to obtain a tempered martensite that combines ductility, corrosion resistance and cavitation resistance.

Applications

It is used for cladding & joining of CA-6NM, 409,410,410S & 405 type of steels.

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Mo	Ni	Cu	Co	S	P
0.030	0.50	0.60	11.60	0.60	4.50	0.040	0.030	0.005	0.012

All Weld Metal Mechanical Properties

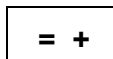
Condition	UTS R _m (Mpa)	YS R _{p0.2} (Mpa)	% Elg A ₅	Impact	
				Temp. °C	J
PWHT 850		690	19	+20°C	45
				-20°C	>30

PWHT: After heat treatment at 610°C/10Hr.

Welding Parameter & Instructions

Welding Mode	Ø of Wire (mm)	Welding Parameter			Shielding Gas
		Current (A)	Voltage (V)	Stick-out (mm)	
FCAW = +	1.20	150-280	25-32	15-25	M21 (Ar +10-20% CO ₂) or CO ₂ 20-25 l/min
	1.60	200-350	26-34	15-25	

Welding positions: 1G/PA ; 2G/PC ; 3G/PF ; 2F/PB



Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended.

The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.