



TIG M13/4

Old reference: TIG 410NiMo

Classification

AWS A5.9 : ER410NiMo
ISO 14343-A : W 13 4

Material N° : ~ 1.4351

Description & Applications

GTAW rod for repair and construction welding of martensitic Cr-Ni steels with a similar composition. These steels / castings are used for hydraulic turbines, pumps, valve bodies, compressor parts... Soft fusion, slag easy to remove, nice aspect of weld bead.

Base materials

Martensitic stainless steels and castings:

UNS	Alloy	EN/ Symbol	Material N°
J91540	CA6-NM	G-X5CrNi13-4	1.4313
S41500		X3CrNiMo13-4	1.4313
		G-X4CrNi13-4	1.4317
		G-X5CrNiMo13-4	1.4407
		X3CrNiMo13-4	1.4413
		G-X4CrNiMo13-4	1.4414

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	P	S	Fe
0.02	0.45	0.5	12.3	4.2	0.5	0.08	<0.03	<0.01	Rem.

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
750	840	19	+20°C 120
After PWHT 580°C / 8h			

Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	Ar : 6-12 l/min Back shielding : Argon/Nitrogen : 3-6 l/min

Ind.10



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