

## ❖ Product Description

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| <ul style="list-style-type: none"> <li>I. Gas shielded, rutile type FCW wire</li> <li>II. Low fumes, very less spatter and slag removed easily</li> <li>III. Modified with less Chromium and more Nickel to eliminate ferrite in the microstructure</li> </ul> | <ul style="list-style-type: none"> <li>IV. Resistance to intergranular corrosion and scaling</li> <li>V. Uniform and good weld bead appearance</li> <li>VI. Typical 11.5Cr-4.5Ni-0.50Mo weld deposit</li> <li>VII. Radiographic weld quality</li> </ul> |
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## ❖ Range of Application

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| <ul style="list-style-type: none"> <li>I. Extremely good for welding of for welding of corrosion resisting steels &amp; castings with 12% Cr &amp; 4.5 % Ni, E410, E410S, E405 grade materials</li> <li>II. Suitable for surfacing of steel castings as well as steels of similar composition</li> </ul> | <ul style="list-style-type: none"> <li>III. Also can be used for overlying of mild &amp; C-Mn steels</li> </ul> |
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## ❖ Classification

- AWS/SFA 5.22 E410NiMoT1

## ❖ % Chemical Composition

Type of Wire		C	Mn	Si	S	P	Mo	Cr	Ni	Cu
E410NiMoT1	Min	-	-	-	-	-	0.40	11.0	4.0	-
	Max	0.06	1.00	1.00	0.03	0.04	0.70	12.5	5.0	0.75

## ❖ Mechanical Properties of all weld metal

Condition	UTS, MPa (Min)	YS, MPa (Min)	% Elongation	Charphy "v" Notch Impact @ -30°C
PWHT	520	-	20	-

## ❖ Wire Size & Welding Position

- Diameter in mm- 1.2, 1.6
- Weld Position- All position

## ❖ Current & Gas Flow

- DCEP; 18-25lit/min

## ❖ Packaging

- Standard packaging in 15kg Spool form

### Special Notes: -

- (1) All the value above mentioned are typical values.
- (2) Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

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