

NOUVE[®] 410NiMo-16

Designation

AWS A5.4 E410NiMo
UNS No. W41016

Welding Positions



Features

- Excellent arc characteristics
- Low spatter level
- Quick & easy slag removal
- Low moisture re-absorption
- Low smoke level
- Radiography quality

Applications

Solid welding wire of the 12% Cr, 4.5% Ni, 0.5% Mo type. 410NiMo is used for welding similar martensitic and martensitic-ferritic steels in different applications, such as hydro turbines.

Recommended Welding Techniques

GENERAL : Electrode positive, work negative (DCEP)
ARC LENGTH : Short arc
STORAGE : Re-dry electrodes 250°C to 300°C for 1 hour before use.

Weld Metal Chemistry

	Carbon	Chromium	Nickel	Molybdenum	Nb+Ta	Manganese	Silicon	Phosphorous	Sulphur	Copper
AWS	0.06	11.0-12.5	4.0-5.0	0.40-0.70	-	1.0	1.0	0.04	0.03	0.75
Typical	0.052	12.14	4.3	0.59	-	0.85	0.83	0.032	0.028	0.55

Mechanical Properties (as welded)

MECHANICAL TESTS	Tensile Strength	Elongation % in 2"
AWS SPEC	760	15
TYPICAL	790	18