

WT-410NiMo



- KS :
- AWS : A5.22 E410NiMoT1-1(4)
- JIS : Z3323 TS410NiMo-FB1

MSDS : [WT-410NiMo.pdf](#)

Applications

WT-410NiMo is designed for MAG welding of soft-martensite stainless alloys of the 13%Cr-4%Ni-Mo types.

Characteristics on Usage

- WT-410NiMo is a titania type flux cored wire for all position welding.
- It features very good ductility, CVN toughness and crack resistance.
- Arc stability is excellent, so spatter loss is low and slag covering is uniform with good removability.

Notes on Usage

- The shielding gas should be used 100% CO₂ or Ar+20~25% CO₂ for welding.
- Gas flow rate is proper 20~25ℓ /min.
- Preheat at 150~300°C and PWHT at 600°C.

Sizes Available and Recommended Currents (DC +)

Dia(mmØ)	Current(A)	Voltage(V)	Electrode extension(mm)
1.2	180~340	24~33	10~20
1.6	200~400	24~33	15~25

Typical Chemical Composition of All-Weld-Metal (wt%) (Shielding gas : CO₂)

C	Mn	Si	P	S	Cr	Ni	Mo	Cu
0.06	0.85	0.55	0.022	0.012	12.3	4.4	0.42	0.02

Typical Mechanical Properties of All-Weld-Metal (Shielding gas : CO₂)

Y.S MPa	T.S MPa	EL(%)	PWHT
780	900	18	600°C X 1Hr

Welding positions

