MX-A410NiMo PREMIARC™

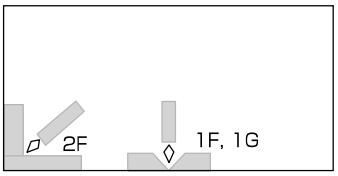
Flux cored wire

Features:
- Suitable for 13%Cr-Ni steel
- Preheat (100℃) must be done depending on thickness of base metal

Classification: AWS A5.22 EC410NiMo

Shielding gas: Ar-CO_2
Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Spool
1.2	12.5kg
Volume mm	295W, 110H, 295L

Composition (all-weld metal mass%)

	Typical	Guaranty [a]
C	0.02	0.06
Si	0.3	0.5
Mn	0.5	0.6
P	0.02	0.03
S	0.01	0.03
Ni	4.2	4.0~5.0
Cr	12.0	11.0~12.5
Mo	0.5	0.4~0.7
Cu	0.03	0.75

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F
1.2	180~320

All-weld mechanical properties

	Typical
0.2%YS (MPa)	870
TS (MPa)	920
El on 4d (%)	20
IV 0℃ (J)	64
PWHT (℃xh)	600x1