

KM-410NiMo

Classification

Shielding Gas: Ar+1~2%O₂
Ar+1~2%CO₂

AWS A5.9/A5.9M ER410NiMo

Applications and Features

- (1) Weld metal is martensite structure with 12%Cr-4.5%Ni-0.5%Mo.
- (2) It is suitable for welding turbines, valve bodies and high pressure piping in offshore and Power generation industries

Welding Instruction

- (1) Use Ar blend with 1~2%O₂ for high current, spray transfer welding .
- (2) Use Ar blend with 1~2%CO₂ for low current, short-circuit transfer welding.

Typical Chemical Composition of Wire (wt%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.016	0.35	0.58	0.016	0.008	11.84	4.54	0.53

Typical Mechanical Properties of Weld Metal (Shielding Gas : Ar+2% O₂)

- After PWHT at 620°C for 1 hour

Tensile Strength MPa	Yield Strength MPa	Elongation %
885	840	22

Size and Suggested Operating Range (DC+)

Shielding Gas	Diameter (mm)	
	1.2	
Ar+1~2%CO ₂	Amp	110~220
	Volt	17-22
Ar+1~2%O ₂	Amp	200-300
	Volt	24~30

Diam.	15 kg Spool
1.2mm	KM410NiM12

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