

Shield-Bright 410NiMo

AWS A5.22 E410NiMoT1-1[4] / JIS Z3323 TS410NiMo-FB1

Description and Application

- Shield-Bright 410NiMo is an all-positional gas shielded flux cored wire for fabrication and repair of hydroelectric turbine “runners” and other similar applications. Its spray-like transfer enhances the arc characteristics while minimizing post-weld clean up and rework.

The ease of use and “use-friendly” characteristics minimize training while producing consistent quality welds. The self-peeling slag removal and easy post-weld clean up minimize the cost to deposit while improving performance efficiency. This electrode is designed for use with Ar/CO₂ shielding gas (75 to 80% Argon, balance CO₂). All product is packaged in a “vacuum sealed” foil bag to prevent moisture absorption.

Flux
CORED
WIRES

Shielding Gas : 100%CO₂ or 75%Ar/25%CO₂

Typical Mechanical Properties of All Weld Metal

Shielding gas	Yield Point N/mm ² {kgf/mm ² }	Tensile Strength N/mm ² {kgf/mm ² }	Elongation (%)	PWHT
100%CO ₂	938 {94}	970 {99}	19	600°C × 1hrs
75%Ar/25%CO ₂	767 {78}	927 {94}	17	600°C × 1hrs

Typical Undiluted Weld Metal Analysis %

Shielding gas	C	Mn	Si	P	S	Cr	Ni	Mo
100%CO ₂	0.025	0.34	0.40	0.020	0.004	11.60	4.75	0.45
75%Ar/25%CO ₂	0.027	0.50	0.70	0.020	0.004	11.30	4.50	0.50