



Product Data Sheet

G 'Gas-shielded metal-arc welding'

OK Autrod 410NiMo

Prepared by Mats Linde	Qualified by Tero Borg	Approved by Jay A Coubrough	Reg no EN007151	Cancelling EN004965	Reg date 2016-03-15	Page 1 (2)
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REASON FOR ISSUE

Chemistry ranges ammended

GENERAL

A continuos solid welding wire of 12% Cr, 4,5% Ni, 0,5% Mo type.

OK Autrod 410NiMo is used for welding of similar martensitic and martensitic-ferritic steels in different applications such as for instance hydro turbines.

Shielding Gas: M12, M13 (EN ISO 14175)

Alloy Type: Martensitic-ferritic (12 % Cr - 4.5 % Ni - 0.5 % Mo)

CLASSIFICATIONS Wire Electrode

EN ISO 14343-A G 13 4

APPROVALS

Not applicable

CHEMICAL COMPOSITION

	Wire/Strip (%)	
	Min	Max
C		0.05
Si	0.2	0.5
Mn	0.2	0.9
P		0.025
S		0.020
Cr	11.5	13.0
Ni	4.0	5.0
Mo	0.4	1.0
Cu		0.3
Others tot		0.50

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal

Properties	As welded	Stress relieved 600°C 2h	Stress relieved 600°C 8h
	Typ	Typ	Typ
Rp0.2 (MPa)	860	850	750
Rm (MPa)	1050	900	850
A5 (%)	13	17	20
Charpy V at 0°C (J)	35	70	75
Charpy V at -20°C (J)	30	55	75



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ECONOMICS & CURRENT DATA

Dimension (mm) Ø	Current (A)		W Nom	η Nom	H		Feed			U Max
	Min	Max			Min	Max	Min	Max	Min	
0.8	50	140	12		0,8	2,7	3,4	11	16	22
0.9										
1.0	80	190	15		1,1	3,1	2,9	8,4	16	24
1.2	180	280	18		2,6	4,5	4,9	8,5	20	28

W = Gas consumption (l / min)

η = Recovery, g weld metal / 100g wire (%)

H = Deposit rate (kg weld metal / hour arc time)

Feed = Feeding rate (m/min)

U = Arc voltage (V)