



Product Data Sheet

W 'Tungsten inert gas arc welding'

OK Tigrod 410NiMo

Signed by Mats Linde	Approved by Per-Åke Pettersson/Christos Skodras	Reg no EN005054	Cancelling EN004168	Reg date 2009-11-25	Page 1 (1)
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REASON FOR ISSUE

Shielding Gas Standard up date.

GENERAL

Bare welding rods of "410NiMo" type alloyed with 13 % Cr, 4.5 % Ni and 0.5 % Mo.

This alloy is used for welding of similar martensitic and martensitic-ferritic steels in different applications such as for example hydro-turbines.

Shielding Gas: I1 (EN ISO 14175)

Alloy Type: Martensitic-ferritic (13 % Cr - 4.5 % Ni - 0.5 % Mo)

CLASSIFICATIONS Wire Electrode

EN ISO 14343 W 13 4

APPROVALS

Not applicable

CHEMICAL COMPOSITION

	All Weld Metal (%)	Wire/Strip (%)	
	Nom	Min	Max
C	0.01		0.05
Si	0.3	0.2	0.5
Mn	0.7	0.5	0.9
P	0.01		0.025
S	0.01		0.020
Cr	12.3	11.5	13.0
Ni	4.5	4.0	5.0
Mo	0.5	0.4	1.0
Cu			0.3
Others tot			0.50

MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal	
	Min	Typ
	Stress relieved 600°C 2h	
Rp0.2 (MPa)	500	600
Rm (MPa)	750	800
A4-A5 (%)	15	17