EXECUTIVE 410NiMo-16

STAINLESS STEEL
COATED ELECTRODE TECHNICAL DATA SHEET

DESCRIPTION

Executive 410 NiMo provides superior weldability, low spatter and smooth beads with easy slag removal. Weld metal is suitable for welding AISI 410 and AISI 420 types of stainless steel.

Weld metal deposited by these electrodes is modified to contain less chromium and more nickel than weld metal deposited by E410 electrodes. The objective is to eliminate ferrite in the microstructure, as ferrite has a deleterious effect on mechanical properties of this alloy.

Final postweld heat treatment should not exceed 1150°F (620°C). Higher temperatures may result in re-hardening due to untempered martensite in the microstructure after cooling to room temperature.

APPLICATIONS & FEATURES

Provides outstanding crack resistance. Suitable for welding 13%Cr-Ni cast steel, such as SCS5 and CA6NM.

Used for welding ASTM CA6NM (CA-6NM) castings or similar materials, as well as light-gauge Type 410,41OS, and 405 base metals.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Si	Mn	P	S	Cr	Ni	Mo	Cu
0.01	0.30	0.24	0.028	0.005	11.53	4.98	0.53	0.04

Tensile Strength: 123,300 PSI min **Yield Strength:** 108,400 PSI min **Elongation:** 22%

TYPICAL WELDING PARAMETERS

Process	Diameter	Length	Amperage
SMAW	3/32"	12"	40-70
AC/DC	1/8"	14"	60-100
	5/32"	14"	90-140
	3/16"	14"	120-185

STANDARD PACKAGING & HANDLING

SMAW 40-lb master box
10-lb plastic tube

CLASSIFICATION

AWS/SFA 5.4, Class **E410NiMo-16**