

DESCRIPTION

Executive 410NiMo wire is designed to provide clean and consistent welds with excellent feedability and minimal clean-up. By maintaining tight control from the country of melt to the design of the spool Executive wire provides welders with the highest quality stainless bare wire.

Executive 410NiMo is modified to contain less chromium and more nickel to eliminate ferrite in the microstructure as it has a deleterious effect on mechanical properties.

APPLICATIONS & FEATURES

Executive 410NiMo is used to overlay mild and low alloy steels, suitable for turbines, valve bodies, high pressure piping, offshore and power generation.

Final post weld heat treatment should not exceed 1150°F (620°C), as higher temperatures may result in re-hardening due to untampered martensite in the microstructure after cooling to room temperature.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Cr	Ni	Mo	Mn	Si	P	S	Cu	N
0.018	12.16	4.08	0.44	0.41	0.37	0.016	0.008	0.13	0.047

Tensile Strength:	118,000 PSI min	Elongation:	20%
Yield Strength:	92,000 PSI min		

TYPICAL WELDING PARAMETERS

Process	Diameter	Voltage	Amperage	Gas Flow	Shielding Gas / Flux
GMAW - Short - Spray	.035"	21-22	160-200	30 to 50 CFH	98% Ar / 2% O ₂
	.045"	22-23	180-210		
	.035"	23-25	190-260		90% Ar / 10% O ₂
	.045"	25-28	250-330		
GTAW	.093"	Direct Current; Electrode -		30 to 40 CFH	100% Ar
SAW	.093"	29-32	300-350		Record IN Flux
	.125"	29-32	400-550		

STANDARD PACKAGING

GMAW (MIG)	33-lb wire baskets	1,980-lb pallet
	11-lb plastic spools	11-lb box
	2-lb plastic spools	8-lb box
GTAW (TIG)	10-lb plastic tube	40-lb box
SAW	60-lb wire coil	1,200-lb pallet



CLASSIFICATION

AWS/SFA 5.9, Class **ER410NiMo**