

DESCRIPTION

Executive 410NiMoP is an all-position gas shielded flux cored wire that provides superior weldability, low spatter and smooth beads with easy slag removal. This an easy to use wire that helps minimize post weld clean – up. Designed to be used with Argon/CO₂ shielding gas (75-80% Argon, balance CO₂)

APPLICATIONS & FEATURES

Executive 410NiMoP is used in fabrication and repair of hydro turbine runners, as well as welding CA6NM castings or similar metals.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Cr	Ni	Mo	Mn	Si	P	S	Cu
0.02	11.87	4.68	0.50	0.30	0.25	0.01	0.01	0.10

Tensile Strength: 113,100 PSI min
Yield Strength: PSI min

Elongation: 25%

TYPICAL WELDING PARAMETERS

Diameter	Voltage	Amperage	WFS (in/min)	Shielding Gas*
.045"	24	130	225	100% CO ₂ or Ar + 20-25% CO ₂
.045"	27	175	320	
.045"	30	240	530	
.062"	27	195	152	100% CO ₂ or Ar + 20-25% CO ₂
.062"	31	260	260	
.062"	34	320	360	

*Shielding gas flow rate 35 to 50 CFH. For 100% CO₂ use two volts higher than shown

STANDARD PACKAGING

FCAW 33-lb plastic spools 1,980-lb pallet

CLASSIFICATION

AWS/SFA 5.22, Class **E410TNiMoT1-1/4**

