



Product Data Sheet

G 'Gas-shielded metal-arc welding'

Weld M 410NiMo

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REASON FOR ISSUE

The new product.

GENERAL

A continuous 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

Properties	All Weld Metal		
	As welded Typ	Stress relieved 600°C 2h Typ	Stress relieved 600°C 8h Typ
Rp0.2 (MPa)	860	850	750
Rm (MPa)	1050	900	850
A5 (%)	13	17	20
Charpy V at 20°C (J)	35	70	75
Charpy V at -20°C (J)	40	55	75