SFC-410NiMo

AWS A5.22 E410NiMoT1-1/-4
EN ISO 17633-A T 13 4 P C1/M21 2
GB T17853 E410NiMoT1-1

FLUX CORED WIRES FOR STAINLESS STEEL

DESCRIPTION & APPLICATIONS :

- SFC-410NiMo is a martensitic structure, the weld metal contains 13%Cr-5%Ni-0.5%Mo the flux-cored wire for the high temp. resistance use.
- It is suitable for ASTM CA6NM series of martensitic stainless steel in all welding positions.

NOTE ON USAGE :

- Use CO_2 within gas purity of 99.8% upward for gas shield, and the flow with 20~25 l/min.
- Preheat at 150 ~ 300°C before welding, and the PWHT at 600 ~ 620°C afterwards.

WELDING POSITION :

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) : (CO_2)

C	Mn	Si	P	S	Ni	Cr	Mo
0.04	0.31	0.25	0.014	0.008	4.39	11.85	0.55

TYPICAL MECHANICAL PROPERTIES OF WELD METAL: (CO_2)

TENSILE STRENGTH $N/mm^2(Kgf/mm^2)$	ELONGATION RATE %	IMPACT VALUES 0°C J(Kgf-m)	HEAT TREATMENT
860(87.8)	17	38(3.9)	620°Cx1hr

SIZE AND RECOMMENDED CURRENT RANGE : DC(+)

Parameters \ Diameter (mm)	1.2		1.6	
	F , H	V , OH	F , H	V , OH
Voltage (Volt)	23-36	22-26	28-36	--
Current (Amp)	130-250	120-160	180-300	--