

INERTFIL 410NiMo

MIG-MAG Wires Stainless and Heat resistant steels

Inertfil 410NiMo is a solid wire suitable for welding AISI 410 NiMo. These are self-hardening steels and usually require pre-heating and stress relieving treatments in order to obtain adequate ductility.

Classification	
AWS	A5.9: ER 410 NiMo
EN	12072: G 13 4

Approvals	Grades

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
0.05	0.60	0.50	≤ 0.030	≤ 0.020	12.50	4	0.70	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) 20°C	Hardness
As Welded	≥ 500	≥ 760	≥ 20	≥ 47	-

Gas test: Acc. To EN 439: M13(Cargal1)

Shielding Gas: Acc. To EN 439: M13(Cargal1)

Materials

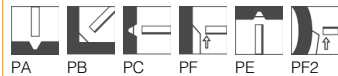
ASTM CA6NM; G-X5CrNi 13-4; Z6 CND 1304 M

Storage

Keep dry and avoid condensation.

Current condition and welding position

DC+



Packaging data: BS300 Kg. 15

Diameters	1,0	1,2				
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