

INERTROD 410NiMo

TIG Rods Stainless and Heat resistant steels

Inertrod 410NiMo is a TIG rod 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 joint ductility.

Classification	
AWS	A 5.9: ER 410 Ni Mo
EN	12072: W 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	≤ 0.030	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
PWHT 620°C x 1h	≥ 550	≥ 760	≥ 20	≥ 47	-

Gas test: Acc. To EN 439: I1(Arcal1)

Shielding Gas: Acc. To EN 439: I1(Arcal1)









Materials

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

Storage

Keep dry and avoid condensation

Current condition and welding position

DC-							
							
PA	PB	PC	PG	PF	PE	PG2	PF2

Packaging data:

Diameters (L: 1000 mm)	1,6	2,0	2,4			

Further forms of delivery on request.