OK Autrod 410NiMo

A continuos solid welding wire of 12% Cr, 4,5% Ni, 0,5% Mo type. OK Autrod 410NiMo is used for welding of martensitic and martensitic-ferritic stainless steels in applications such as hydro turbines.

Specifications	
Classifications	EN ISO 14343-A : G 13 4

Alloy Type	Martensitic-ferritic (12 % Cr - 4.5 % Ni - 0.5 % Mo)
Shielding Gas	M12, M13 (EN ISO 14175)

Tensile_Properties			
Testing Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
As Welded	860 MPa	1050 MPa	13 %
Stress Relieved 2 hour(s) 600 °C	850 MPa	900 MPa	17 %
Stress Relieved 8 hour(s) 600 °C	750 MPa	850 MPa	20 %

Charpy Testing		
Testing Condition	**Testing Temp**	**Impact Value**
As Welded	0 °C	35 J
As Welded	-20 °C	30 J
Stress Relieved	0 °C	70 J
Stress Relieved	-20 °C	55 J
Stress Relieved	0 °C	75 J
Stress Relieved	-20 °C	75 J

Typical Wire Composition %								
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**Cu**
0.02	0.43	0.37	0.004	0.017	4.5	12.2	0.4	0.07

Typical Weld Metal Analysis %								
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**Cu**
0.02	0.38	0.37	0.003	0.019	4.5	12	0.4	0.1

Deposition Data				
Diameter	**Amps**	**Volts**	**Wire Feed Speed**	**Deposition Rate**
1.2 mm	180-280 A	20-28 V	4.9-8.5 m/min	2.6-4.5 kg/h

Welding_Parameters
Wire Diameter
0.9 mm