

OK Tigrod 410NiMo

Bare welding rods of "410NiMo" type alloyed with 13 % Cr, 4.5 % Ni and 0.5 % Mo. This alloy is used for welding of similar martensitic and martensitic-ferritic steels in different applications such as for example hydro-turbines.

Specifications

Classifications	EN ISO 14343-A : W 13 4
Alloy Type	Martensitic-ferritic (13 % Cr - 4.5 % Ni - 0.5 % Mo)
Shielding Gas	I1 (EN ISO 14175)

Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
Stress Relieved 2 hour(s) 600 °C	930 MPa	1000 MPa	17 %
Stress Relieved 8 hour(s) 600 °C	770 MPa	870 MPa	22 %

Charpy Testing

Testing Condition	Testing Temp	Impact Value
Stress Relieved	0 °C	120 J
Stress Relieved	-20 °C	120 J
Stress Relieved	0 °C	175 J
Stress Relieved	-20 °C	165 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
0.02	0.4	0.4	0.01	0.02	4.5	12	0.4