



S. R. Industries

STAR ARC ER410NiMo

ER410NiMo is extensively used to weld cast and wrought material of similar chemical composition. Preheating and inter pass temperature of not less than 300°F is required.

AWS Specification : AWS A5.9/A5.9M:2006

AWS Classification	ER410NiMo
<i>Welding Current</i>	<i>DCEP</i>
Typical Wire Chemistry	
<i>C</i>	<i>0.06</i>
<i>Cr</i>	<i>11.0 - 12.5</i>
<i>Ni</i>	<i>4.0 - 5.0</i>
<i>Mo</i>	<i>0.4 - 0.7</i>
<i>Mn</i>	<i>0.6</i>
<i>Si</i>	<i>0.5</i>
<i>P</i>	<i>0.03</i>
<i>S</i>	<i>0.03</i>
<i>Cu</i>	<i>0.75</i>
Typical Mechanical Properties (As Welded post heat treatment between 1100° and 1150° F for one hour)	
<i>Yield Strength, ksi</i>	<i>92</i>
<i>Tensile Strength, ksi</i>	<i>118</i>
<i>Elongation%, min</i>	<i>20</i>
<i>Welding Positions</i>	<i>F,V,OH,H</i>
Available Diameters MIG with Operating Range in Amps	

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<i>.030"</i>	<i>50 - 100</i>
<i>.035"</i>	<i>160 - 210</i>
<i>.045"</i>	<i>180 - 250</i>
<i>Available Diameters TIG with Operating Range in Amps</i>	
<i>.035"</i>	<i>60 - 90</i>
<i>.045"</i>	<i>80 - 110</i>
<i>1/16"</i>	<i>90 - 130</i>
<i>3/32"</i>	<i>120 - 175</i>
<i>1/8"</i>	<i>150 - 220</i>
<i>5/32"</i>	<i>170 - 350</i>

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