

ESSEN[®] FC 410NiMo

AC/ DC +

Grade: AWS A5.22 E410NiMoT1-1/4

All position Martensitic stainless-steel Flux Cored wire for welding of AISI types 403, 405, 410. Surfacing of carbon steel to resist corrosion, erosion or abrasion. Deposition efficiency is particularly high.

PROPERTIES

- Provides excellent usability with stable arc, less spatter and high deposition.
- Titania type flux cored containing Cr: 12%, Ni:4.5%, Mo:0.5%
- Slag removal is excellent.

TYPICAL ANALYSIS OF ALL -WELD METAL %

C	Si	Mn	P	Cr	Ni	Mo
0.03	0.40	0.6	0.015	12.00	4.50	0.5

TYPICAL ANALYSIS OF ALL -WELD METAL %

Tensile Strength MPa	Yield Strength MPa	Elongation %	Hardness HRc
490	---	20	32-35

WELDING PARAMETERS :

Polarity	Shielding Gas	Amps A	Voltage V
DC+	Ar +5 - 25% CO ₂	150-240	24-32

PACKING

Wire Dia in MM.	Packaging per spool
1.20	12.5 Kgs



ESSEN
WELDING ALLOYS PVT. LTD.



ESSEN & AZUCAR
PREMIUM WELDING ALLOYS

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