

RAAJER410NiMo

Ferrite-Martensitic steel solid welding wire for TIG/ MIG welding

CLASSIFICATION : AWS A5.9 ER410NiMo
EN ISO: 14343-B 13 4

CHARACTERISTICS & APPLICATION : ER410NiMo is Ferrite-Martensitic type solid welding wire 12Cr, 4.5Ni, 0.55Mo. It is primarily designed for welding ASTM CA6NM casting or similar material. As well as light gauge 410,410S, and 405 metals. Filler metal of this classification is modified to contain less Cr and more Ni to eliminate ferrite in the microstructure.

SHIELDING GAS : welding with 100% Ar or Mixed gas (80Ar/20Co2)

CHEMICAL COMPOSITION % (solid wire chemistry)

C	Mn	Si	S	P	Ni
0.06 max.	0.60 Max.	0.50 Max.	0.030 Max	0.030 Max	4.0-5.0
Cr	Mo				
11.00-12.50	0.40-0.70				

DIEMENSION, CURRENT CONDITION & PACKING DATA (RAAJMIGER41NiMo)

Size(mm)	Size(inch)	Current Condition (DC+)	Voltage (V)	Gas Flow Rate L/min.	Spool packing 12.5 kg.	Spool packing 15 kg	Drum packing 100/200kg
0.80	0.031	60-180	16-24	10-20	√	√	X
1.20	0.047	120-300	24-34	15-25	√	√	√
1.60	1/16"	150-350	28-36	15-30	√	√	√

DIEMENSION, CURRENT CONDITION & PACKING DATA (RAAJTIGER410NiMo)

Size(mm)	Size(inch)	Length (mm)	Length (inch)	Current Condition (DC+)	Voltage (V)	Tube packing 5 kg	Box packing 20 kg
1.60	1/ 16"	1000	36"	40-80	10-16	√	√
2.0	5/ 64"	1000	36"	50-100	12-18	√	√
2.4/ 2.5	3/ 32"	1000	36"	60-120	14-20	√	√
3.2	1/ 8"	1000	36"	100-150	16-24	√	√
4.0	5/ 32	1000	36"	140-200	18-28	√	√

Raajratna offer a wide range of Stainless Steel welding wires for MIG/TIG/SAW.

Customer packing on request.