

Product Data Sheet



BRAND NAME VJ ER410NiMo

AWS/ASME Class ER410NiMo

SPECIFICATION SFA A5.9

Features and Applications :

VJ ER410NiMo is designed for welding cast and wrought materials of similar composition. It requires controlled preheat and inter-pass temperature during welding. Ideally suited for guide vanes, runners, valve seat hard-facing, and turbine blades in hydro power plants.

CHEMICAL COMPOSITION :

All Weld Metal (%)			
TYPICAL	Max	TYPICAL	Max
C	0.03	Mn	0.45
Cr	11.80	Si	0.40
Ni	4.50	S	0.010
Mo	0.55	P	0.015
Cu	0.75		

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal - PWHT 600°C - 1 HR	
Properties	Typical
UTS (MPa)	800
El (%)	19

DIMENSIONS:

Dimension (mm)	
GMAW	GTAW
0.80	1.6
1.20	2.0
1.60	2.4
	3.2

GMAW CURRENT : DC (+)	SHIELDING GAS: ARGON
GTAW CURRENT : DCEN	SHIELDING GAS: ARGON

PACKING :

GTAW : 5 kg wire put in a plastic container. Identification AWS code is punched on side of wire.

GMAW : The wire can be supplied in plastic spool packed in a cardboard box weighing 15.0 kg.

WELDING POSITION:

