

## DATASHEET RW 410 NiMo – MIG wire

### Description and Applications

Stainless steel welding wire used for welding similar martensitic and martensitic-ferritic steels in different applications, such as hydro turbines. Final PWHT should not exceed 620 °C because higher temperatures may result in rehardening due to untempered martensite after cooling to room temperature.

### Rodacciai denomination and approximate equivalent with other standards

#### RW 410 NiMo

EN ISO 14343-A:2009 G 13 4  
EN ISO 14343-B:2009 (SS 410 NiMo)  
AWS A5.9-2012 (ER 410 NiMo)

### Filler metal properties

Chemical composition (nominal) in %

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Co	N
min		0,30	0,20			11,50	4,00	0,40			
max	0,025	0,80	0,50	0,015	0,025	12,50	5,00	0,70	0,30	0,20	0,060

### Metal properties

The following data are typical for PWHT 600°C/8hr (Post weld heat treatment) weld metal from MIG welding.

### Expected minimum mechanical properties of all weld metal

Yield strength, Rp 0,2 N/mm<sup>2</sup> 680  
Tensile strength, Rm N/mm<sup>2</sup> 800  
Elongation, A5 % 15  
Impact energy, ISO – V J 50 at 20 °C

### Packaging forms

Blue metallic wire baskets BS300 of 15 kg.

Plastic spools D300 of 12,5 kg for 0,80 mm and of 15 kg for the other diameters.

Plastic spools D200 of 5 kg.

Drum packaging of about 150 kg for diameter 0,80 mm and of about 250 kg for the other diameters.

Diameters : 0,80 – 0,90 – 1,00 – 1,20 – 1,60 mm.