

Shield-Bright 410NiMo

Shield-Bright 410NiMo is an all-positional gas shielded flux cored wire for fabrication and repair of hydroelectric turbine "runners" and other similar applications. Its spray-like transfer enhances the arc characteristics while minimizing post-weld clean up and rework. The ease of use and "user-friendly" characteristics minimize training while producing consistent quality welds. The self-peeling slag removal and easy post-weld clean up minimize the cost to deposit while improving performance efficiency. This electrode is designed for use with Argon/CO₂ shielding gas (75 to 80% Argon, balance CO₂).

Specifications

| | |
|------------------------|-------------------------------|
| Classifications | AWS A5.22 : E410NiMoT1-1/T1-4 |
| Approvals | JIS Z3323 : TS410NiMo-FB1 |
| Industry | Power Generation |

Approvals are based on factory location. Please contact ESAB for more information.

Typical Tensile Properties

| Condition | Yield Strength | Tensile Strength | Elongation |
|------------------------------------|----------------|------------------|------------|
| 100% CO₂ | | | |
| PWHT 1 hour(s) 600 °C | 938 MPa | 970 MPa | 19 % |
| 75% Ar - 25% CO₂ | | | |
| PWHT 1 hour(s) 600 °C | 767 MPa | 927 MPa | 17 % |

Typical Weld Metal Analysis %

| C | Mn | Si | S | P | Ni | Cr | Mo |
|------------------------------------|------|------|-------|-------|------|-------|------|
| 75% Ar - 25% CO₂ | | | | | | | |
| 0.027 | 0.50 | 0.70 | 0.004 | 0.020 | 4.50 | 11.30 | 0.50 |
| 100% CO₂ | | | | | | | |
| 0.025 | 0.34 | 0.40 | 0.004 | 0.020 | 4.75 | 11.60 | 0.45 |