OK Tigrod 410NiMo

Bare welding rods of "410NiMo" type alloyed with 13 % Cr, 4.5 % Ni and 0.5 % Mo. This alloy is used for welding of similar martensitic and martensitic-feritic steels in different applications such as for example hydro-turbines.

Specifications	
Classifications	EN ISO 14343-A : W 13 4

Alloy Type	Martensitic-ferritic (13 % Cr - 4.5 % Ni - 0.5 % Mo)
Shielding Gas	I1 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
Stress Relieved 2 hour(s) 600 °C (1112 °F)	930 MPa (135 ksi)	1000 MPa (145 ksi)	17 %
Stress Relieved 8 hour(s) 600 °C (1112 °F)	770 MPa (112 ksi)	870 MPa (126 ksi)	22 %

Typical Charpy V-Notch Properties

Testing Temperature	Impact Value
0 °C (32 °F)	120 J (88.5 ft-lb)
0 °C (32 °F)	175 J (129 ft-lb)
-20 °C (-76 °F)	120 J (88.5 ft-lb)
-20 °C (-76 °F)	165 J (122 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo
0.02	0.4	0.4	0.01	0.02	4.5	12	0.4

Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu
0.02	0.43	0.37	0.004	0.017	4.5	12.2	0.4	0.07