

# TMS-410NiMo

AWS A5.22 EC410NiMo

## Characteristics and Applications:

TMS-410NiMo is a gas-shielded metal-cored wire. It is low hydrogen levels and excellent impact toughness at 0°C. It is generally used for welding of ASTM CA6NM castings, materials, with similar composition, and turbines of hydro plant.

## Notes on usage:

1. Before welding, oil, rusty, and moisture should be cleaned off the base material that should have the proper protection from the wind in welding site.
2. Use with mix gas (75~80% Argon and 25~20% CO<sub>2</sub>).
3. Require pre-heat and inter-pass temperature 150°C~260°C, and post weld heat treatment.

## Typical chemical composition of weld metal (wt%):

C	Mn	Si	P	S	Cr	Ni	Mo
0.031	0.45	0.29	0.009	0.008	11.70	4.50	0.50

## Typical mechanical properties of weld metal:

Tensile strength MPa(ksi)	Elongation (%)	Charpy V-Notch J (ft-lbf) 0°C (32°F)	PWHT
860(125)	20	38(28)	610°C×1hr

## Welding position:



## Sizes and recommended parameter range (DC<+>):

Stick out:15-20(mm),flow rate:20-25(l/min):

Position	Diameter (mm)	
		1.2
F, HF		180A-250A/24V-28V

FLUX CORED WIRES

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