TFW-410NiMo

AWS A5.22 E410NiMoT1-1 EN ISO 17633-B-TS 410NiMo F C1 1

Characteristics and Applications:

TFW-410NiMo is a gas-shielded flux-cored wire with better control of 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. Use 99.8% or higher purity of CO₂ as shielding gas.
- 2 Require pre-heat and inter-pass temperature at 150°C~260°C, and post weld heat treatment.
- 3. Keep the product dry, while it is stored or delivered.

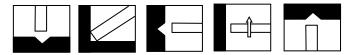
Typical chemical composition of weld metal (wt%):

	С	Si	Р	S	Мо	Mn	Ni	Cr
AWS	≦ 0.06	≦1.0	≦0.04	≦0.03	0.40-0.70	≦1.0	4.0-5.0	11.0-12.5
EN ISO	0.06	≦1.0	≦0.04	≦0.03	0.40-0.70	≦1.0	4.0-5.0	11.0-12.5
Typical value	0.047	0.45	0.015	0.008	0.54	0.40	4.10	12.18

Typical mechanical properties of weld metal:

	Tensile strength MPa(ksi)	Elongation %	Charpy V-Notch J (ft-lbf) 0°C (32°F)	PWHT
AWS	760(110)	15	-	593-621°Cx 1hrs
EN ISO	760(110)	10	-	590-620°Cx 1hrs
Typical value	875(127)	19	40(30)	610°Cx 1hrs

Welding position:



Sizes and recommended parameter range (DC<+>): Stick out:15-20(mm),flow rate:20-25(I/min):

Diameter (mm) Position	1.2		
F, HF	150A-220A/25V-33V		
Н	140A-180A/25V-29V		
V-UP	130A-180A/24V-28V		
ОН	150A-180A/25V-29V		

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