

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%):

	C	Si	P	S	Mo	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(l/min):

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

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