

OK Autrod 410NiMo

A continuous solid welding wire of 12% Cr, 4,5% Ni, 0,5% Mo type. OK Autrod 410NiMo is used for welding of similar martensitic and martensitic-ferritic steels in different applications such as for instance hydro turbines.

Classifications	EN ISO 14343-A : G 13 4
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Alloy Type	Martensitic-ferritic (12 % Cr - 4.5 % Ni - 0.5 % Mo)
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Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	860 MPa	1050 MPa	13 %
Stress Relieved 2 hour(s) 600 °C	850 MPa	900 MPa	17 %
Stress Relieved 8 hour(s) 600 °C	750 MPa	850 MPa	20 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	0 °C	35 J
As Welded	-20 °C	30 J
Stress Relieved 2 hour(s) 600 °C	0 °C	70 J
Stress Relieved 2 hour(s) 600 °C	-20 °C	55 J
Stress Relieved 8 hour(s) 600 °C	0 °C	75 J
Stress Relieved 8 hour(s) 600 °C	-20 °C	75 J

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	Cu
0.02	0.5	0.4	4.2	12.4	0.6	0.1

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
0.8 mm	50-140 A	16-22 V	3.4-11.0 m/min	0.8-2.7 kg/h
1.0 mm	80-190 A	16-24 V	2.9-8.4 m/min	1.1-3.1 kg/h
1.2 mm	180-280 A	20-28 V	4.9-8.5 m/min	2.6-4.5 kg/h

Recommended Welding Parameters

	Current	Voltage