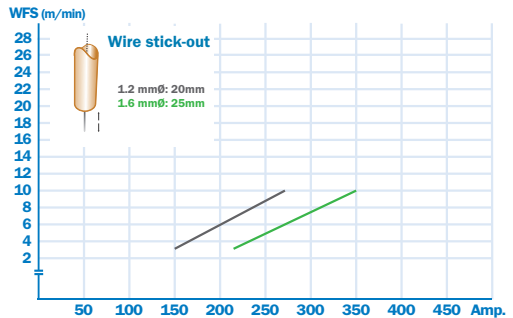
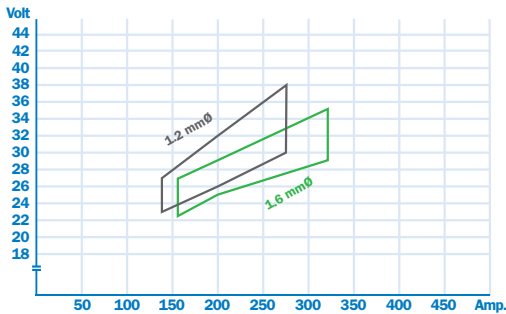


Description and Application

DW-410NiMo is a rutile flux cored wire of which deposit has 12Cr-4Ni-0.5Mo type weld metal. It is suitable for the welding of 410NiMo type martensitic stainless steel such as CA6NM which is a common base material for hydro turbine components.



Recommended Parameter Range, for flat position



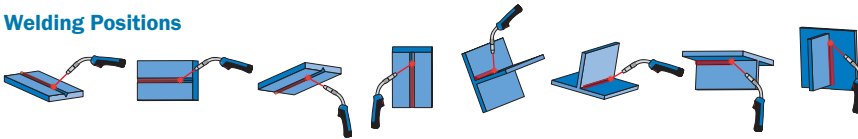
Typical Chemical Analysis (wt. %)

C	Si	Mn	P	S	Ni	Cr	Mo	N	Nb	FS	FN	FNW
0.02	0.34	1.52	0.024	0.004	4.30	11.6	0.55	-	-	-	-	-

Typical Mechanical Properties

	R _e (MPa)	R _m (MPa)	A ₅ (%)	CV (J) -20°C	PWHT
Guaranty	846	926	17	44	600°C x 1hr AC
	-	min.760	min.15		

Welding Positions



Approvals

LR	DNV GL	BV	ABS	R.M.R.S	Others
-	-	-	-	-	-