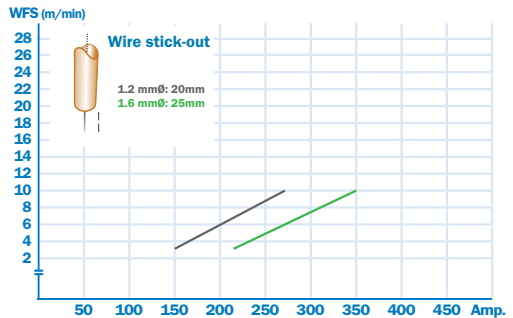
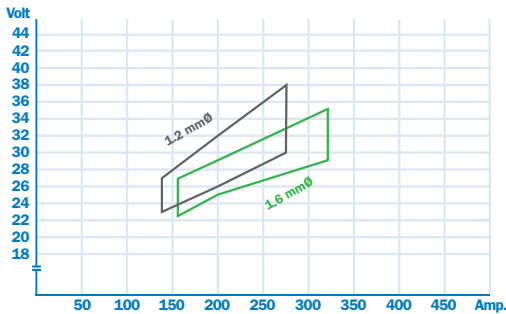


Description and Application

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



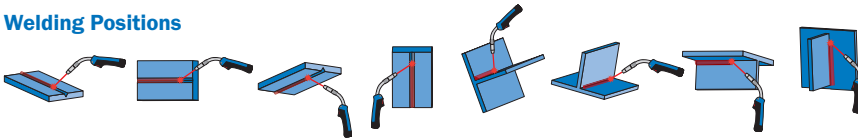
Typical Chemical Analysis (wt. %)

| 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 | BV | ABS | R.M.R.S | Others |
|----|-----|----|-----|---------|--------|
| - | - | - | - | - | - |