MIDALLOY CHROMAX E410NiMo-16 COATED ELECTRODE

CLASSIFICATION

- AWS A5.4 Classification E410NiMo-16 / ASME SFA 5.4 Classification E410NiMo-16
- UNS# W41016
- ASME Sec. IX F#4 A#None

DESCRIPTION

- MIDALLOY CHROMAX E410NiMo-16 is an AC-DC titania coated electrode
- Designed for single or multipass welding in all positions, and deposits a low carbon, martensitic stainless steel. Normally the chromium is kept low and the nickel is kept high to avoid ferrite formation in the weld metal.

APPLICATIONS

- MIDALLOY CHROMAX E410NiMo-16 finds wide application in power generation equipment, such as turbine blades and vanes. It is widely used to weld ASTM CA6NM castings as well as 410, 410S and 405 stainless steels.

TYPICAL CHEMISTRY

C	Mn	Si	Cr	Ni	Mo	Cu	S	P
0.03	0.72	.55	11.5	4.53	0.5	0.3	.015	.015

TYPICAL MECHANICAL PROPERTIES *

TENSILE STRENGTH	110,500 PSI
YIELD STRENGTH	91,000 PSI
ELONGATION IN 2”	17%

***PWHT 1125F for 1 hr**

RECOMMENDED WELDING PARAMETERS

DIAMETER	AMPERAGE	
	FLAT	VERTICAL & OVERHEAD
3/32”	70-85	65-75
1/8”	85-110	80-90
5/32”	110-140	100-120
3/16”	120-160	110-130

STANDARD PACKAGING

- 3/32” - 8 lb. can, 48 lb. Carton
- 1/8”, 5/32”, 3/16” - 10 lb. Can, 60 lb. Carton

7/1/16

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