

## Stainless solid wire

### Classification

AWS A5.9 :ER 410NiMo  
 EN 14343-A :G 13 4  
 \* Nearest classification

### General Description

Stainless welding wire with 12%Cr, 4,5%Ni, 0,5%Mo. 410NiMo applicable for welding of materials and martensitic-ferritic steels. Applicable for welding of hydro turbines

### Shielding gases (acc. EN 439)

GTAW I1 Inert gas

### Chemical composition (w%), typical, all weld metal

C	Mn	Si	Cr	Mo	Ni
0.03	0.70	0.80	13.0	0.5	4.7

### Mechanical properties, all weld metal

	Process	Shielding gas	Condition	0.2% Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation (%)	Impact (ISO), J +20°C
Typical values after welding	GTAW	I1	AW	690	750	15	50

### Materials to be welded

1.4313  
 1.4002  
 (G)X5CrNi(Mo) 13 4  
 X6CrAl13  
 Grade CA 6 NM

### Packaging, available sizes and identification

Process	Unit:	Sizes, mm		
		1.0	1.2	1.6
GTAW	5 kg tube	X	X	X
GMAW	15 kg spool B300	X	X	X
	300 kg metal coil		X	X

Identification

Imprint: Revicor®410NiMo

Tip colour:

Revicor®410NiMo : rev.EN 20