



Shield-Bright 410NiMo

Shield-Bright 410NiMo is an all-positional gas shielded flux cored wire for fabrication and repair of hydroelectric turbine "runners" and other similar applications. Its spray-like transfer enhances the arc characteristics while minimizing post-weld clean up and rework. The ease of use and "user-friendly" characteristics minimize training while producing consistent quality welds. The self-peeling slag removal and easy post-weld clean up minimize the cost to deposit while improving performance efficiency. This electrode is designed for use with Argon/CO₂ shielding gas (75 to 80% Argon, balance CO₂).

Process

- FCAW (Flux Core)

Specifications

Classifications	AWS A5.22 : E410NiMoT1-1/T1-4
Approvals	JIS Z3323 : TS410NiMo-FB1
Industry	Power Generation

Approvals are based on factory location. Please contact ESAB for more information.

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
100% CO ₂			
PWHT 1 hour(s) 600 °C	938 MPa	970 MPa	19 %
75% Ar - 25% CO ₂			
PWHT 1 hour(s) 600 °C	767 MPa	927 MPa	17 %

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo
75% Ar - 25% CO ₂							

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo
0.027	0.50	0.70	0.004	0.020	4.50	11.30	0.50
100% CO₂							
0.025	0.34	0.40	0.004	0.020	4.75	11.60	0.45