

Product Data Sheet

SUPER OPTIMAL 410NIMO

MMA Electrodes
Stainless & Heat Resistant Steels

Classification	
AWS	A5.4 : E 410NiMo-15
EN	1600 : E 13 4 B 22

Description: Basic coated special type MMA electrodes for welding of stainless martensitic chromium nickel steels or cast steels. Deposited weldmetal is corrosion, erosion and pitting resistant. Excellent resistance to abrasion. These steels are air hardening and therefore pre-heating and stress relieving treatments are required to obtain a suitable ductility to allow mechanical working.

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Cu
0.03	0.55	0.30	0.03	0.010	11.50	4.60	0.50	0.09

All-weld metal Mechanical Properties (Typical)

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)
PWHT 610°C × 1h/air or 610 C X5h	≥ 600	≥ 850	≥ 15

Materials

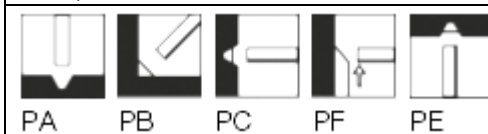
1.4313 (X4CrNi13-4); 1.4413 (X3CrNiMo13-4)
1.4407(G-X5CrNiMo13-4); 1.4414(G-X4CrNiMo 13-4); AISI 410 NiMo

Storage and redrying

Keep dry and avoid condensation.
Re-drying not generally required, If necessary:
280-300°C for 1 hour, 5 times max

Current condition and welding position

DC+; AC



Amperes

2.50m	3.15m	4.00m	5.00m
60 – 80	80 – 110	110 – 160	180 – 220

Special Characteristics

Hardness: As welded 350 BHN (Approx.)

SUPERON SCHWEISSTECHNIK (INDIA) LTD.

Corporate Office: 552, Sector-37, Pace City-II, Gurgaon, Haryana – 122001, India

Ph : +91-11-24647252, 24647199, 24638360, 24652337, 24649831 Fax : +91-11-24623826, 24633847

E-mail : sales@superonindia.com Web site : www.superonindia.com

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