

KFW-410NiMo

Classification

AWS	A5.22	E410NiMoT1-1/4
JIS	Z3321	-
EN	12072	T 13 4 P C/M 1
GB	T 17853	E410NiMo T1-1/4

Shielding Gas: CO₂ or Ar+20%CO₂

Applications and Features

- (1) KFW-410NiMo performs with smooth arc transfer, low spatter level, fine ripple, good heat and corrosion resistance.
- (2) It is suitable for welding ASTM CA6NM castings or similar materials.

Welding Position

All Positions

Welding Instruction

- (1) For other instructions, please refer to Appendix D.
- (2) For extra information, please refer to Appendix F.

Typical Chemical Composition of Weld Metal (wt%) (Shielding Gas : CO₂)

C	Si	Mn	P	S	Cr	Ni	Mo
0.05	0.332	0.577	0.025	0.06	12.09	4.264	0.501

Typical Mechanical Properties of Weld Metal (Shielding Gas : CO₂)

Tensile Strength N/mm ² (kgf/mm ²)	Elongation %
780	25

Size and Suggested Operating Range (DC+)

Diameter (mm)	F/H-fillet		V/OH	
	Amp	Volt	Amp	Volt
1.2	100~300	20~36	100~200	24~30
1.6	200~360	26~40	—	—