

FCAW

MX-A410NiMo

PREMIARC™

Flux cored wire

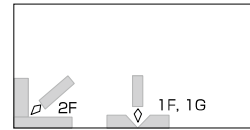
- Features:**
- Suitable for 13%Cr-Ni steel
 - Preheat (100°C) must be done depending on thickness of base metal

Classification: AWS A5.22 EC410NiMo

Shielding gas: Ar-CO₂

Polarity: DCEP

Welding Positions:



Packaging data

φ mm	Spool
1.2	12.5kg
Volume mm	295W, 110H, 295L

Composition (all-weld metal mass%)

	Typical	Guaranty ^a
C	0.02	0.06
Si	0.3	0.5
Mn	0.5	0.6
P	0.02	0.03
S	0.01	0.03
Ni	4.2	4.0~5.0
Cr	12.0	11.0~12.5
Mo	0.5	0.4~0.7
Cu	0.03	0.75

Note: ^a Single values are maximum.

Welding parameters (A)

φ mm	1F, 1G, 2F
1.2	180~320

All-weld mechanical properties

	Typical
0.2%YS (MPa)	870
TS (MPa)	920
EI on 4d (%)	20
IV 0°C (J)	64
PWHT (°Cxh)	600x1