



WB410NiMoM M.I.G. WELDING WIRE

Classifications	AWS A5.9: ER410NiMo BSEN12072-00 : 13 4L									
Product Description	Martensitic 410NiMo / (13/4) stainless steel, solid MIG wire.									
Applications	WB410NiMoM is used mainly for welding and repairing BS3100 425C11, ASTM F6NM/S41500. Widely used for turbines, valve bodies, pump casings, piping etc.									
Wire Composition(Weight %)	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	
min.	-	0.4	0.20	-	-	11.0	4.0	0.4	-	
max.	0.06	1.2	0.60	0.03	0.03	12.5	5.0	0.7	0.75	
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength					N/mm ²	890			
	Yield Stress/0.2% Proof Stress					N/mm ²	850			
	Elongation on 5D					%	20			
	Impact Energy CV @ 0°C					Joules	90			
	PWHT @ 610°C/1Hr									

Wire Dia (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	min.	-	80	120	160	180	-	-
	max.	-	180	240	260	300	-	-
Volt Range (Volts)	min.	-	17	17	18	20	-	-
	max.	-	20	22	26	29	-	-
Packaging Information								
Kg Per Reel		-	15	15	15	15	-	-
Storage	Storage It is recommended that the WB range of wires are stored in a dry heated store at a minimum temperature of 18°C, and a maximum relative humidity of 60%.							
Gases	Gas Pure Argon or Argon + 2%O ₂ mixture Flow Rate 12-16 l/min							

Current Conditions DC+ and Welding Positions

