

Standards:

EN ISO 3581-A: E 13 4 B 42
 EN 1600: E 13 4 B 42
 AWS A 5.4: E 410 NiMo-25
 Mat.-No.: 1.4351

Recovery: 150%

capilla® 410 NiMo

Product description:

Basic coated stick electrode for overlay and joint welding of ferritic-martensitic chromium steels. The weld metal is corrosion resistant as similar alloyed chromium (nickel) steels and exhibits a very good resistant against wear and cavitation, especially when used as material of hydraulic turbines. If thick-walled components have to be preheated at 200°C, a post weld heat treatment should be performed to improve the toughness of weld and base metal.

Applications:

The electrode is suitable for overlay and fusion welding of 13 % chromium (nickel) steels.

Suitable for materials such as:
 1.4313, 1.4001, 1.4002.

Typical weld metal composition:

[wt. - %]

	C	Cr	Ni	Mo	Mn	Fe
Min.		11,5	3	0,5		
Max.	0,1	14,5	5	1	0,7	Bal.

Mechanical properties:

(Heat treatment: 600°C/8h; Minimum values at ambient temperature)

Tensile strength R_m :	800	[MPa]
Yield strength $R_{p0,2}$:	600	[MPa]
Yield strength $R_{p1,0}$:	-	[MPa]
Elongation (L=5d):	25	[%]
Hardness:	310	[HB 30]
	38	[HRC] without heat treatment

Positions: all except PD, PE and PG

Redrying: 320°C/2h

Dimension:

Ø [mm]	Length [mm]	Welding current [A]	Polarity
2,5	350	60 – 90	=(+)
3,25	350	80 – 110	
4,0	350	100 – 150	

also available:
 find in table of content

Capilla 410 NiMo MAG
 Capilla 410 NiMo WIG
 Capilla G 135 MM (tubular wire)

Capidur 410 NiMo