

# TFW-410NiMo

AWS A5.22 E410NiMoT1-1

## Characteristics and Applications:

TFW-410NiMo is a gas-shielded flux-cored wire with better control of hydrogen levels and excellent impact toughness at 0 . It is generally used for welding of ASTM CA6NM castings, materials, with similar composition, and turbines of hydro plant.

## Notes on usage:

1. Use 99.8% or higher purity of CO<sub>2</sub> as shielding gas.
2. Require pre-heat and inter-pass temperature at 150 ~260 , and post weld heat treatment.
3. Keep the product dry, while it is stored or delivered.

## Typical chemical composition of weld metal (wt%):

C	Si	P	S	Mo	Mn	Ni	Cr
0.047	0.45	0.015	0.008	0.54	0.40	4.10	12.18

## Typical mechanical properties of weld metal:

Tensile strength MPa(ksi)	Elongation %	Charpy V-Notch J (ft-lbf) 0°C (32 )	PWHT
875(127)	19	40(30)	610 x 1hrs

## Welding position:



## Sizes and recommended parameter range (DC + ):

Stick out:15-20(mm),flow rate:20-25(l/min):

Diameter (mm)		1.2
Position		
F, HF		130A-220A/24V-33V
H		140A-180A/25V-29V
V-UP		130A-180A/24V-28V
OH		150A-

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FLUX CORED WIRES