# **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  $CO_2$  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.

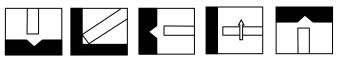
## Typical chemical composition of weld metal (wt%):

С	Si	Р	S	Мо	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(I/min):

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

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