WEARcore 410 NiMo-S (SK 410 NiMo-SA)

SAW cored wire

Classifications

EN 14700	DIN 8555
T Fe7	UP 5-GF-40-C

Characteristics

Alloy depositing a ferritic-martensitic steel containing 13 % Chromium, 5 % Nickel and 1% Molybdenum designed to resist metal-to-metal wear, corrosion and thermal fatigue fire cracking.

Microstructure:	Martensite + 10 % Ferrite
Machinability:	Good with carbide tipped tools
Oxy-acetylene cutting:	Cannot be flame cut
Deposit thickness:	Depends upon application and procedure used
Welding flux:	Record SA

Field of use

Continuous casting rollers.

Typical analysis in %

C	Mn	Si	Cr	Ni	Mo	Fe
0.05	1.0	0.3	12.5	5.0	0.9	balance

Typical mechanical properties

Hardness as welded: 39 HRC

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Flux-Rate [kg per kg wire]	Travel Speed [cm/min]
2.8	300 – 400	28 – 30	30 – 35	1.1	35 – 45
3.2	325 – 500	28 – 32	30 – 35	1.1	40 – 50