



Hard-Facing FCW - High Temp. Fatigue and corrosion resistant



Code & Specification

ASME SFA/AWS A5.22 E410NiMoT1-1

Description

BLUME® E410NiMo is a gas shield type hard-facing flux cored arc welding wire. This hard-facing flux cored wire obtains a martensite structure weld metal. **BLUME® E410NiMo** has a good crack resistance, high compressive abrasion resistance and good thermal fatigue resistance.

Shielding Gas

Carbon Dioxide (CO₂) / Mixed Gas

Applications

BLUME® E410NiMo is designed for hard-facing repair welding of hydro turbines and castor guide roller along with build up repair for various guide rollers.

Mechanical Properties

Hardness HRC (As Welded)	42
Tensile Strength, MPa	923
Elongation % (L=4d)	18
Abrasion Resistance	Excellent
Thermal Fatigue Resistance	Excellent
Crack Resistance	Excellent

Undiluted Weld Metal Analysis (wt%)

C	Mn	Si	Ni	Cr
≤ 0.06	≤ 1.00	≤ 1.00	4.00 - 5.00	11.0 - 12.5
Mo				
0.40 - 0.70				

Suggested Welding Parameters (DC+)

Diameter	Wire Extension		
	Volts	Amps	mm
1.2mm (.045")	20 - 32	150 - 250	15 - 25
1.6mm (1/16")	22 - 34	200 - 300	15 - 25

Packaging

15 kgs (33 lbs) [Net Weight] Plastic spools with OD = 270mm (11")

Approvals



Note: All values are based on CO₂ welding gas for weld test.

