

MMA Electrodes Stainless and Heat resistant steels

BASINOX 410 NiMo S is a basic coated MMA electrode for welding martensitic 13% chromium-nickel steels or cast steels. Despite the high strength, the weld metal has excellent toughness. For wall thicknesses >10mm, preheating <150 °C is recommended. After welding a tempering or a normalising and tempering treatment is required.

Classification

EN	1600: E 13 4 B 42
AWS	A5.4: E 410NiMo-15

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo
≤ 0.05	0.8	0.5	≤ 0.025	≤ 0.02	11.5	4.5	0.5

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				+20 °C	-60 °C
610 °C x 1h/air or 610°C x 5h	≥ 600	≥ 850	≥ 15	≥ 47	≥ 32

Materials

1.4407 (G-X5CrNiMo13-4); 1.4414 (G-X4CrNiMo13-4)

1.4313 (X4CrNi13-4); 1.4413 (X3CrNiMo13-4)

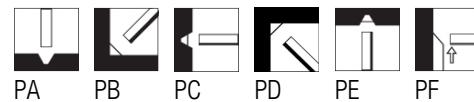
Storage

Keep dry and avoid condensation.

Re-dry 280-300 °C for 2 hours, 5 times max.

Current condition and welding position

DC+



Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	VPMD	
				PC	Code
2.5	300	65-95	18.5	100	●
3.2	350	85-140	38.4	55	●
4.0	350	120-190	56.8	40	●
5.0	350	190-240	82.8	25	●