

Stainless Steel Flux Cored Wire

GMX410NiMo

AWS A5.22 E410NiMoT1-1/4
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JIS Z 3323 TS410NiMo-FB1

Product Features:

- Gas shield type hardfacing flux cored arc welding wire.
- Martensite structure weld metal.
- Good crack resistance, high compressive abrasion resistance and good thermal fatigue resistance.

Applications:

- Hardfacing repair welding of caster guide roller.
- Build-up repair for various guide rollers.

Typical chemical composition of all-weld metal (wt%)

C	Si	Mn	Ni	Cr	Mo	Fe
0.02	0.37	0.61	4.3	11.58	0.53	Bal.

Typical characteristics of weld metal

Tensile Strength N/mm ²	Elongation %
947	17

Size & recommended welding parameters

Diameter	1.2mm	1.6mm
Polarity	DC+	DC+
Ampere	100~260	120~280
Wire extension (mm)	15~25	15~25
Shielding Gas	CO ₂ /80%Ar+20%CO ₂	CO ₂ /80%Ar+20%CO ₂

Note:

Goodweld Corporation
No.99, Huangong Rd. Yongkang Tainan, Taiwan
Phone: 886-6-2331003 Fax: 886-6-2333213
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www.goodweld.com.tw