

### DESCRIPTION

Executive 410NiMo wire is designed to provide clean and consistent welds with excellent feedability and minimal clean-up. By maintaining tight control from the country of melt to the design of the spool Executive wire provides welders with the highest quality stainless bare wire.

Executive 410NiMo is modified to contain less chromium and more nickel to eliminate ferrite in the microstructure as it has a deleterious effect on mechanical properties.

### APPLICATIONS & FEATURES

Executive 410NiMo is used to overlay mild and low alloy steels, suitable for turbines, valve bodies, high pressure piping, offshore and power generation.

Final post weld heat treatment should not exceed 1150°F (620°C), as higher temperatures may result in re-hardening due to untampered martensite in the microstructure after cooling to room temperature.

### TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Cr	Ni	Mo	Mn	Si	P	S	Cu	N
0.018	12.16	4.08	0.44	0.41	0.37	0.016	0.008	0.13	0.047

**Tensile Strength:** 118,000 PSI min      **Yield Strength:** 92,000 PSI min      **Elongation:** 20%

### TYPICAL WELDING PARAMETERS

Process	Diameter	Voltage	Amperage	Gas Flow	Shielding Gas / Flux
<b>GMAW</b> - Short  - Spray	.035"	21-22	160-200	30 to 50 CFH	90% He/7.5% Ar/2.5% CO <sub>2</sub> or 1%-5% O <sub>2</sub> /Balance Ar
	.045"	22-23	180-210		
	.062"	23-24	200-220		
	.035"	23-25	190-260		
	.045"	25-28	250-330		
	.062"	28-31	310-350		
<b>GTAW</b>	.062" - .125"	Direct Current; Electrode -		30 to 40 CFH	100% Ar
<b>SAW</b>	.093"	29-32	300-350		Record IND 24 or Record IN
	.125"	29-32	400-550		

### STANDARD PACKAGING

<b>GMAW</b> (MIG)	33-lb wire baskets	1,980-lb pallet
	11-lb plastic spools	11-lb box
	2-lb plastic spools	8-lb box
<b>GTAW</b> (TIG)	10-lb plastic tube	40-lb box
<b>SAW</b>	60-lb wire coil	1,200-lb pallet

### CLASSIFICATION

AWS/SFA 5.9, Class **ER410NiMo**

