

Stainless Steel Electrodes

Alloy: WW410NiMo-16

Class: E410NiMo-16

Conforms to Certification: AWS A5.4 ASME SFA A5.4

Alloy: E410NiMo-16

Weld Process: Shielded Manual Metal Arc

AWS Chemical Composition Requirements

C = 0.06 max	Si = 0.90 max
Cr = 11.0 – 12.5	P = 0.04 max
Ni = 4.0 – 5.0	S = 0.03 max
Mo = 0.40 – 0.70	Cu = 0.75 max
Mn = 1.0 max	

Deposited All Weld Metal Properties %
(Typical) As-Welded

Yield Strength	134,000psi
Tensile Strength	123,000psi
Elongation	18%

Deposited Chemical Composition % (Typical)

C = 0.05	Si = 0.40
Cr = 11.70	P = 0.020
Ni = 4.50	S = 0.019
Mn = 0.75	Mo = 0.50

Deposited Charpy-V-Notch Impact Properties %

Not Applicable

Recommended Welding Parameters

<u>Diameter</u>	<u>Voltage</u>	<u>Amperage Flat Position</u>	<u>Amperage Vertical & Overhead</u>
3/32	24-28	70-85	65-75
1/8	26-30	85-110	80-90
5/32	28-32	110-140	100-120
3/16	28-32	120-160	110-130

Application

E410NiMo-16 is designed to weld materials of similar chemical composition in cast and wrought iron forms. Preheat and interpass of less than 300°F is recommended. Post-weld heat treatment should not exceed 1150°F.

