



GEN 410NiMo Welding Wire and Rod

GEN 410NiMo is primarily designed for welding ASTM CA6NM casting or similar materials. It may also be used for welding light gauge 410, 410S, and 405 base materials. Final postweld heat treatment should not exceed 1150°F (620°C) as higher temperatures may result in re-hardening.

CONFORMANCES

AWS A5.9/A5.9M : ER410NiMo
 ASME SFA-A5.9 : ER410NiMo
 ISO 14343-B : SS410NiMo

AWS CHEMICAL COMPOSITION (TYPICAL)

%C	%Cr	%Ni	%Mo	%Mn
0.06 max	11.0 – 12.5	4.0 – 5.0	0.4 – 0.7	0.60 max

%Si	%P	%S	%Cu	Total Others
0.50 max	0.03 max	0.03 max	0.75 max	0.50 max

TYPICAL WELD METAL MECHANICAL PROPERTIES

Yield Strength : 92,000 psi
 Tensile Strength : 117,000 psi
 Elongation (min.) : 20 %

TYPICAL WELDING PARAMETERS

Process	Diameter	Voltage	Amperage	Gas/Flux
TIG (GTAW)	1/16"	14 – 16	90 – 130	100% Ar
	3/32"	15 – 20	120 – 180	100% Ar
MIG (GMAW)	.035"	24 – 29	150 – 220	98%Ar – 2%O ₂
	.045"	25 – 30	160 – 260	98%Ar – 2%O ₂
Sub Arc (SAW)	.093"	28 – 32	250 – 450	
	.125"	29 - 34	300 – 500	

*All parameters are suggested as basic guidelines only and will vary depending on joint design, number of passes and other factors.

IMPORTANT: SPECIAL VENTILATION AND/OR EXHAUST REQUIRED BEFORE USE, READ AND UNDERSTAND THE SAFETY DATA SHEET (SDS) FOR THIS PRODUCT AND SPECIFIC INFORMATION PRINTED ON THE PRODUCT CONTAINER.
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