

COR™STAIN 410NiMo FC

DESCRIPTION

COR™STAIN 410NiMo FC is an AWS flux-cored, modified 410 stainless steel designed to improve mechanical properties by reducing the chromium, and increasing the nickel and molybdenum. This wire is formulated for flat position welding, but the metal-cored version has been used successfully out of position in the pulsed arc mode.

APPLICATIONS

410NiMo FC is used to weld ACI 6NM castings, 410, 430, and 405 stainless steels, and joining or overlaying areas subject to stress corrosion, and cavitation erosion. Specific applications include turbine runners, blades, and other accessories.

PROCEDURE

Preheat according to base material.

WELDING PARAMETERS

Type	Size	Volts	Amps	Shielding Gas	Stickout
MC-G	.045"	19-21	150-200	100% CO ₂	0.5"
FC-G	.045"	22-28	150-250	100% CO ₂	0.5"
FC-G	1/16"	26-30	200-300	100% CO ₂	0.75"
FC-O	3/32"	29-31	450-650	none	1.5"
FC-O	7/64"	30-32	500-800	none	1.5"

Submerged arc wires are available in 1/16"-5/32"; Suggested fluxes: Lincoln ST-100, 880M, or 880.

MECHANICAL PROPERTIES

Hardness: 30-35 Rc
 Tensile: 110,000 psi minimum
 Elongation: 15% minimum

CLASSIFICATION

AWS A5.22, Class E410NiMoT0-1 or E410NiMoT0-3