

# CSF-410NiMo

For 13%Cr-4%Ni-Mo Stainless steel

AWS A5.22 E410NiMoT0-1/-4  
JIS Z3323 TS410NiMo-FB0

## Applications

CSF-410NiMo is suitable for welding of AISI types 403, 405 and 410. Surfacing of carbon steel to resist corrosion, erosion or abrasion.

## Characteristics

- (1) CSF-410NiMo is flux cored wire and designed for Fillet & H-F welding with 80%Ar + 20%CO<sub>2</sub> Shielding.
- (2) It provides the excellent usability with stable arc, less spattering, good bead appearance, better slag removal, and less quantity of welding fume comparable to solid wire.
- (3) Is containing Ferrite of a reasonable quantity and crack-resistance, intergranular corrosion resistance, mechanical properties of weld metal is superior.
- (4) Shield gas is 80%Ar + 20%CO<sub>2</sub> gas.

## Notes on usage

- (1) The optimum flow of 80%Ar + 20%CO<sub>2</sub> for Shielding is 20~25 ℓ /min.
- (2) Protect the weld with a screen to prevent blowholes caused by wind where the wind velocity is 2m/sec and more.
- (3) Keep the distance between tip & base metal at 15~25mm.

## Typical chemical composition of weld metal (%)

(80%Ar+20%CO<sub>2</sub>)

C	Mn	Si	P	S	Cr	Ni	Mo
0.03	0.60	0.40	0.015	0.015	12.0	4.5	0.5

## Typical mechanical properties of weld metal

(80%Ar+20%CO<sub>2</sub>)

TS N/mm <sup>2</sup> (MPa)	EL %	Hardness (H <sub>R</sub> C)	Heat Treatment
487	505	22	600°CX2hr - S.R

## Size & recommended current range (DC+)

Dia. mm (in)	Current(A)	Voltage(V)	Welding Speed(cm / min)
1.2(0.045)	150~300	24~33	20~60
1.6(0.062)	200~400	24~33	20~60