

# TFW-410NiMo

JIS Z 3323 TS410NiMo-FC1  
AWS A5.22 E410NiMoT1-1  
EN 12073 T 13 4 P C 2

## Characteristics and Applications:

TFW-410NiMo is a gas-shielded flux-cored wire with better control of hydrogen levels and excellent impact toughness at 0°C. It is generally used for welding of ASTM CA6NM castings, materials, with similar composition, and turbines of hydro plant.

## Notes on Usage:

1. Use 99.8% or higher purity of CO<sub>2</sub> as shielding gas.
- 2 Pre-heat and inter-pass temperature 150°C~260°C, and post weld heat treatment.

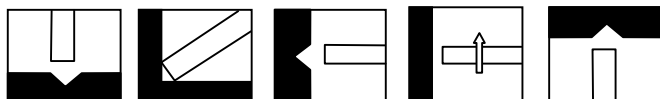
## Typical chemical composition (wt%) :

C	Si	P	S	Mo	Mn	Ni	Cr	Cu
0.040	0.28	0.015	0.008	0.45	0.27	4.50	11.30	0.01

## Typical mechanical properties of weld metal :

TS (MPa)	EL %	CVN 0°C J	PWHT
875	19	46	610°C x 1hrs

## Welding position



## Sizes and recommended current range (DC <+>)

Diameter (mm)	1.2	
Welding condition	A	V
F、HF	130-220	24-33
H	140-180	25-29
V-UP	130-160	24-28
OH	150-180	25-29

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