Solid Wire Electrode for Submerged Arc Welding

BA-WIRE 410NiMo

Classification:

EN ISO 14343-A	– **S 13 4**
SFA-5.9	– **ER410NiMo**

Typical analysis and chemical composition acc. to EN ISO 14343-A and AWS A5.9: (Weight Percent)

Wire electrode	C	Si	Mn	Mo	Ni	Cr	P	S	Cu total
Typical analysis BA-WIRE 410NiMo	0.03	0.35	0.4	0.6	4.5	12.0	0.015	0.015	0.2
S 13 4 acc. to ISO 14343-A	0.05	1.0	1.0	0.4–1.0	3.0–5.0	11.0–14.0	0.03	0.02	0.5
ER410NiMo acc. to AWS A5.9	0.06	0.5	0.6	0.4–0.7	4.0–5.0	11.0–12.5	0.03	0.03	0.75

Application:
Wire electrode for submerged arc welding intended for welding martensitic 13 % chromium-nickel steels. Also used for overlaying mild and low alloy steels. Applications in turbines, valve bodies, high-pressure piping, offshore, and power generation.

Base Materials:
- 1.4407 (G-X5CrNiMo13-4); 1.4414 (G-X4CrNiMo13-4)
  1.4313 (X4CrNi13-4); 1.4413 (X3CrNiMo13-4)
  Suitable fluxes: BF 38, WP 380

Flux type suitability is strongly dependent on its application. In combination with the wire electrode the most suitable flux should match the requirements of the plate material as closely as possible under the existing welding conditions. Further information can be obtained from the technical flux data sheets.

Package forms:
Coils, spools, drums and spiders as standard package forms for SAW-wire electrodes, different package forms on request.

Diameter:
1.6 – 4.0 mm; sizes and tolerances acc. to ISO 544 and AWS A5.9.

Wire electrode Surface:
Smooth finish free from surface defects and foreign matter.