



In-Flux[®] 410NiMoT1

AWS A5.22 E410NiMoT1-4/-1 H4

Replaces 060203

190-L Index: 121212

DESCRIPTION:

In-Flux 410NiMoT1 is a low carbon martensitic stainless steel deposit used for joining Type CA-6NM stainless steel castings as well as for joining Types 409, 410, 410S and 405 stainless steels.

Features	Benefits
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| <ul style="list-style-type: none"> • All-position (1/16" diameter) • Self-detaching slag • Spray-like transfer • High moisture resistance | <ul style="list-style-type: none"> • Welds well in vertical (up) position, as well as flat & horizontal • Excellent welder appeal • Low spatter and less clean-up • Good weld soundness and extended shelf-life |
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SHIELDING GAS: 75% Ar-25% CO₂ or 100% CO₂
Polarity: DCEP

TYPICAL WELD METAL CHEMISTRY*(Chem Pad):

Weld Metal Analysis		AWS Spec
Carbon (C)	0.03	0.06 max
Manganese (Mn)	0.30	1.0 max
Phosphorus (P)	0.015	0.04 max
Sulfur (S)	0.016	0.03 max
Silicon (Si)	0.38	1.0
Chromium (Cr)	11.50	11.0-12.5
Nickel (Ni)	4.30	4.0-5.0
Molybdenum (Mo)	0.59	0.4-0.7
Iron (Fe)	Bal.	-

TYPICAL WELD METAL PROPERTIES* (AS WELDED):

	As Welded	Stress Relieved for 1 hr. @ 1150°F	AWS
Tensile Strength	161,900 psi	131,000 psi	110,000 psi min.
Yield Strength	144,900 psi	111,000 psi	--
Elongation % in 2	20%	21% min	15%

NOTE: Test results listed above using 100% CO₂

CONFORMANCES AND APPROVALS:

• AWS A5.22 • ASME SFA 5.22, (F-6, A-8) • AWS E410NiMoT1-4/-1 H4 • Certified to CWB to AWS A5.22/A5.22M:2010, E410NiMoT1-1

*The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and McKay expressly disclaims any liability incurred from any reliance thereon. Typical data are obtained when welded and tested in accordance with AWS A5.22 specification. Other tests and procedures may produce different results. No data is to be construed as a recommendation for any welding condition or technique not controlled by McKay.



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WELDING DATA:

The information listed below was determined by welding performed with DCEP welding current with 75% Ar-25% CO₂.

Diameter	Volts	Amps	Wire Feed Speed	Stickout ±1/4"
1/16"	24-37	130-400	100-600	1/2"-1 1/4"

CAUTION:

Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standard Z49.1, "Safety in Welding and Cutting," published by the American Welding Society, 550 NW LeJune Road, Miami, FL 33126; OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210.

Material Safety Data Sheets on any McKay product may be obtained from McKay Customer Service.

Because McKay is constantly improving products, McKay reserves the right to change design and/or specifications without notice.

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