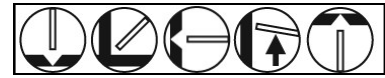


# FabCO® 410NiMoT1



AWS A5.22: E410NiMoT1-4/-1

WELDING POSITIONS:



**FEATURES:**

- All-position (1/16")
- Self-detaching slag
- Spray-like transfer
- High moisture resistance

**BENEFITS:**

- 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

**SHIELDING GAS:** 100% Carbon Dioxide (CO<sub>2</sub>), 75-80% Argon (Ar)/Balance Carbon Dioxide (CO<sub>2</sub>), 35-50 cfm (17-24 l/min)

**TYPE OF CURRENT:** Direct Current Electrode Positive (DCEP)

**STANDARD DIAMETERS:** 1/16" (1.6 mm), 3/32" (2.4 mm)

**STORAGE:** Product should be stored in a dry, enclosed environment, and in its original intact packaging

**RECONDITIONING:** Not recommended

**TYPICAL WELD METAL CHEMISTRY\* (Chem Pad):**

Weld Metal Analysis (%)	100% CO <sub>2</sub>	AWS Spec
Carbon (C)	0.03	0.06
Manganese (Mn)	0.30	1.0
Phosphorus (P)	0.015	0.04
Sulphur (S)	0.016	0.03
Silicon (Si)	0.38	1.0
Chromium (Cr)	11.50	11.0 to 12.5
Nickel (Ni)	4.30	4.0 to 5.0
Molybdenum (Mo)	0.59	0.4 to 0.7
Iron (Fe)	Bal.	—

**Note:** AWS specification single values are maximums

**TYPICAL MECHANICAL PROPERTIES\* (As Welded):**

Mechanical Tests	As Welded	Stress Relieved for 1 hr. @ 1150°F	AWS Spec
Tensile Strength	161,900 psi	131,000 psi	110,000 psi Minimum
Yield Strength	144,900 psi	111,000 psi	—
Elongation % in 2" (50 mm)	20%	21%	15% Minimum

**Note:** Test results listed above using 100% CO<sub>2</sub>

\*The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and Hobart Brothers LLC expressly disclaims any liability incurred from any reliance thereon. Typical data are those obtained when welded and tested in accordance with the 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 Hobart Brothers LLC.

# FabCO® 410NiMoT1

Diameter Inches (mm)	Weld Position	Amps	Volts	Wire Feed Speed	Stick-Out ±1/4"
1/16 (1.6)	Flat & Horizontal	130-400	24-37	100-600	1/2" - 1 1/4"

- Maintaining a proper welding procedure - including pre-heat and interpass temperatures - may be critical depending on the type and thickness of steel being welded.
- All positions include: Flat, Horizontal, Vertical Up, and Overhead

## AVAILABLE DIAMETERS AND PACKAGES:

Diameter Inches (mm)	30-Lb. VPW Spool	60-Lb. Coil
1/16" (1.6)	S681719-073	S681719-002
3/32" (2.4)	—	S681729-002

## CONFORMANCES AND APPROVALS:

- AWS A5.22, E410NiMoT1-4/-1 H4
- ASME SFA 5.22, E410NiMoT1-4/-1 H4 (F-6, A-8)
- Certified to CWB to AWS A5.22-12, E410NiMoT1 H4 (1/16" only)

**TECHNICAL QUESTIONS?** For technical support of Hobart Filler Metals products, contact the Applications Engineering department by phone toll-free at 1-800-532-2618 or by e-mail at [Applications.Engineering@hobartbrothers.com](mailto:Applications.Engineering@hobartbrothers.com)

### 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, 8669 NW 36th St., Miami, FL 33166 (can also be downloaded online at [www.aws.org](http://www.aws.org)); OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210

Safety Data Sheets on any Hobart Brothers LLC product may be obtained from Hobart Customer Service or at [www.hobartbrothers.com](http://www.hobartbrothers.com).

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

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Revision Date: 181029 (Replaces 150723)

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