Inweld 410NiMo

Chemical Composition of Inweld 410NiMo

Fe	C	Cr	Ni	Mo	Mn	Si	P	S	N	Cu
Balance	0.06	11.0-12.5	4.0-5.0	0.4-0.7	0.6	0.5	0.03	0.03	---	0.75

Single values are maximum unless otherwise specified.

Description and Applications

Inweld 410NiMo is primarily designed for welding ASTM CA6NM castings or similar material, as well as light gage 410, 410S and 405 base metals. Filler metal of this calssification is modified to contain less chromium and more nickel to eliminate ferrite in the microstructure as it has a deleterious effect on mechanical properties. Final postweld heat treatment should not exceed 1150ºF (620ºC), as higher temperatures may result in reharden-ing due to untempered martensite in the microstructure after cooling to room temperature.

Typical Weld Metal Properties

	AWS Spec
Tensile Strength:	110,229 psi
Yield Strength:	92,000 psi
Elongation:	15%