



# MODI - 410 NiMo

## STAINLESS STEEL ELECTRODE

**CLASSIFICATION :** AWS/A 5.4 : E 410 NiMo

**CHARACTERISTICS :** A special purpose hard surfacing electrode with excellent operating characteristics working on AC as well as DC. Electrode produces weld metal of approximately 13 Cr, 4 Ni and 0.5 Mo. The weld metal is corrosion, erosion and pitting resistant. It gives outstanding resistance to abrasion. Weld deposit gives the hardness of 325 to 375 BHN (as deposited).

**APPLICATIONS :**

- \* Ideally Suited for Surfacing of Castings of Similar Composition.
- \* Hard Surfacing of High Pressure Valves and Valve Sheets.
- \* Repair of Runner and Re-welding of Turbine Blades.
- \* Pulp and Paper Plant Equipments.
- \* Gas and Steam Turbines

**RECOMMENDATIONS :** Re-dry the electrodes at 200°C for 1 hour. Keep the arc as short as possible. Thick materials to be preheated to 100°C to 120°C and stress relieving may be done at 650°C.

CHEMICAL ANALYSIS OF WELD-METAL(%) (TYPICAL) :	C	Mn	Si	Cr	Ni	Mo	S	P	Cu
	0.08	1.0	0.90	11.0-12.5	4-5	0.4-0.7	0.03	0.04	0.75
	max	max	max				max	max	max

MECHANICAL PROPERTIES OF ALL WELD-METAL (AS PER AWS/A 5.4) (TYPICAL) :	Ultimate Tensile Strength N/mm <sup>2</sup>	Elongation (GL=4d) (%)
	760 min	15 min

**HARDNESS :** 350 BHN

**CURRENT CONDITIONS : USE AC (50V) OR DC (+)**

Size (mm)	3.15x350	4.0x350	5.0x450
Amps	90-120	120-150	150-180



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