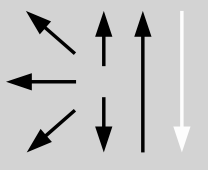


Classifications						
EN ISO 14343-A		EN ISO 14343-B		AWS A5.9		
W 13 4		SS(410NiMo)		ER410NiMo (mod.)		
Characteristics and typical fields of application						
<p>GTAW rod of low-carbon type 13 % Cr 4 % Ni suited for soft-martensitic steels like 1.4313 / CA 6 NM. Designed with precisely tuned alloying composition creating a weld deposit featuring very good ductility, CVN toughness and crack resistance despite its high strength.</p> <p>For applications like hydro- and steam turbines, corrosion resistant against water and steam.</p>						
Base materials						
1.4317 GX4CrNi13-4, 1.4313 X3CrNiMo13-4, 1.4407 GX5CrNiMo13-4, 1.4414 GX4CrNiMo13-4 ACI Gr. CA6NM						
Typical analysis of the TIG rods (wt.-%)						
	C	Si	Mn	Cr	Ni	Mo
wt.-%	0.01	0.7	0.7	12.3	4.7	0.5
Mechanical properties of all-weld metal						
Condition	Yield strength R _{p0,2}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J		
	MPa	MPa	%	+20 °C	-60 °C	
u	915	1000	15	85		
a	750 (≥ 500)	830 (≥ 750)	21 (≥ 15)	150	≥ 32	
u	untreated, as welded – shielding gas Argon					
a	annealed, 600 °C / 8 h / furnace down to 300 °C / air – shielding gas Argon					
Operating data						
	Polarity: DC (-)	Shielding gas: 100 % Argon	Rod marking: front: ✦ W 13 4 back: -	∅ (mm)		
				2.0 2.4		
Preheating and interpass temperatures in case of thick-walled sections 100 – 160 °C. Maximum heat input 15 kJ/cm. Tempering at 580 – 620 °C.						
Approvals						
TÜV (04110.), SEPROZ, CE						