

# BASINOX 410 NiMo

## TOP FEATURES

- Basic coated MMA electrode for welding martensitic 13% chromium-nickel ASTM CA6NM (CA-6NM) castings or similar materials, as well as light-gauge Type 410, 410S, and 405 base metals.
- The weld metal has excellent toughness despite the high strength,
- Preheat-interpass range of 100-200°C is recommended to allow martensite transformation during welding.
- Easy slag release
- Well-suited for positional welding.

## CLASSIFICATION

AWS A5.4	E410NiMo-15
EN ISO 3581-A	E 13 4 B 4 2

## CURRENT TYPE

DC+

## WELDING POSITIONS

All position, except vertical down

## CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	P	S	Cr	Ni	Mo
0.06	0.8	0.5	0.017	0.006	12	4.5	0.5

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	0.2% Proof strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) +20°C
AWS A5.4	PWHT	not specified	≥760	≥15	not specified
EN ISO 3581-A	PWHT	not specified	≥760	≥10	not specified
Typical values	600°C x 1h/air	740	880	20	50

## OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 300	65-95
3.2 x 350	85-140
4.0 x 350	120-190
5.0 x 350	190-240

## PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5x300	VPMD	100	1.9	W000288026
3.2x350	VPMD	55	2.1	W000288027
4.0x350	VPMD	40	2.3	W000288028
5.0x350	VPMD	25	2.1	W000288029

### TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.  
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