

**AWS CLASSIFICATION**    A5.9-2006, Class EC  
410NiMo

**DESCRIPTION**

Stoody 410NiMo-G shielded stainless steel wire is a tubular alloy-cored wire that can be operated as GMAW (MIG) or SAW (Submerged Arc). The tubular wire provides deposition rates equal to that of solid wires at lower amperages. This feature allows less heat input into the work piece and therefore causes less distortion. Penetration, however, is still excellent.

Stoody 410NiMo-G shielded stainless wire is used for application requiring less crack sensitivity and improved weldability.

**OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS**

Diameter, in. (mm)	<b>0.045 (1.2)</b>
Current, Amp. DCEP	180 – 200
Voltage	24 – 26
Wire Extension, in. (mm)	½ - ¾ (13 – 19)
Shielding Gas	98% Ar – 2% O <sub>2</sub>

Diameter, in. (mm)	<b>1/16 (1.6)</b>
Current, Amp. DCEP	220 – 280
Voltage	24 – 26
Wire Extension, in. (mm)	½ - ¾ (13 – 19)
Shielding Gas	98% Ar – 2% O <sub>2</sub>

**TYPICAL DEPOSIT CHEMISTRY (wt%)**

(with 98 Ar / 2 O<sub>2</sub> shielding)

Carbon	0.04
Manganese	0.5
Silicon	0.4
Chromium	12.0
Nickel	4.5
Molybdenum	0.6
Iron	Balance

**STANDARD SIZES & PACKAGING**

Diameter	Packaging	Part #
0.045" (1.2mm)	10# PS	11421700
0.045" (1.2mm)	33# WB	11332700
1/16" (1.6mm)	10# PS	11421600
1/16" (1.6mm)	33# WB	11292000
1/16" (1.6mm)	50# PP	11294200
1/16" (1.6mm)	60# Coil	11437000

**NOTES:**

- Chemical composition values are typical and were developed in accordance with AWS A5.9-2006 procedures. Actual test results may vary depending on welding parameters and base metal composition.

**TYPICAL APPLICATIONS**

- Valves
- Pumps

**Stoody Company**

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PDS-SS-W-004

Revision 1  
01/15/07