STOODY
A Thermadyne Company

Brilliant® 410NiMo T-1 AP
Gas Shielded Flux Cored Wire

AWS CLASSIFICATION A5.22-95 410NiMoT1-4

DESCRIPTION

Stoody® AP stainless steel wires are designed for welding in all positions with Argon / CO_2 gas mixtures. These wires exhibit a spray like arc transfer, easy slag removal and can be welded within a wide range of parameters.

Stoody® 410NiMoT-1 AP wires can be used to join martensitic stainless steels such as 410 used in valve and pump manufacturing. These wires can also be used for the repair and joining of CA-6NM castings.

TYPICAL DEPOSIT CHEMISTRY (wt%)
(with 75 Ar / 25 CO_2 shielding)

Carbon	0.02
Manganese	0.2
Silicon	0.3
Chromium	11.8
Nickel	4.3
Molybdenum	0.6

NOTES:
- Chemical composition values are typical and were developed in accordance with AWS A5.22-95 procedures. Actual test results may vary depending on welding parameters and base metal composition.

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS (DCEP)

1/16" (1.6mm)	
Amps, DCEP	190 - 250
Volts	26 - 27
Shielding Gas	75% Argon / 25% CO_2

NOTES:
- 3/8" - 1/2" (10-12mm) electrical stick out.

TYPICAL DEPOSIT CHARACTERISTICS
Postweld Heat Treated 1125°F (607°C) for 1 hr

Tensile Strength, Ksi (MPa)	134 (880)
Yield Strength, Ksi (Mpa)	118 (776)
Elongation (%)	19
Charpy V-Notch Toughness @ 32°F (0°C)	25ft - lbs (34 Joules)

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
1/16" (1.6mm)	33# WB, Can Pack	11921000

Stoody Company
5557 Nashville Road • Bowling Green, KY 42101
1-800-227-9333

PDS-SS-W-009
Revision 1
02/27/02