

Classifications						
14343-A	AWS A5.9		Mat. No.			
G 13 4	ER410NiMo(mod.)		1.4351			
Characteristics and typical fields of application						
Stainless; corrosion-resistant similar to matching 13 % Cr(Ni) steels/cast steel grades. High resistance to corrosion fatigue cracking. For joining and surfacing applications with matching 13 % Cr(Ni) and 13 % Cr-steels/cast steel grades.						
Base materials						
1.4002 – X6CrAl13 1.4313 – (G)X5CrNi13-4 ACI Gr. CA 6NM						
Typical analysis of solid wire (wt.-%)						
	C	Si	Mn	Cr	Mo	Ni
wt-%	0.03	0.8	0.7	13.0	0.5	4.7
<b>Structure:</b> Martensite, suitable for quenching and tempering						
Mechanical properties of all-weld metal						
Heat-treatment	Yield strength R <sub>p0.2</sub>	Tensile strength R <sub>m</sub>	Elongation A (L <sub>0</sub> =5d <sub>0</sub> )	Impact work ISO-V KV J	Hardness	
	MPa	MPa	%	+20 °C	HB30	HRC
600 °C / 8 h (1112 °F)	680	800	15	50	250	
aw						38
Operating data						
<b>Polarity:</b> DC ( + )	<b>Shielding gas:</b> (EN ISO 14175) M12, M13		<b>ø (mm)</b> 1.0 1.2	<b>Spool:</b> B300 B300		
Welding instruction						
Materials	Preheating		Postweld heat treatment			
Matching steels / cast steel grades	Up to 10 mm wall thickness: none, over 10 mm wall thickness: 100 – 150 °C (212 – 302 °F)		Tempering or quenching and tempering, according to parent metal			
13 % Cr steels / cast steel grades	According to parent metal		Tempering or quenching and tempering, according to parent metal			