

Supershield 410NiMo-0

MARTENSITIC STS TYPE SUBMERGED ARC WIRE

HYUNDAI WELDING CO., LTD.



Supershield 410NiMo-O

❖ Specification

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❖ Description & Applications

Supershield 410NiMo-O is an open arc type wire. Used for Hardfacing of casting rolls. Good weldability(Non-Gas) and PWHT(Post-Weld Heat Treatment) is not required.

(Steel Mill Rolls, Casting Rolls, etc.)

❖ Welding Process

Open Arc Type

❖ Current Type

DC+



❖ Packing

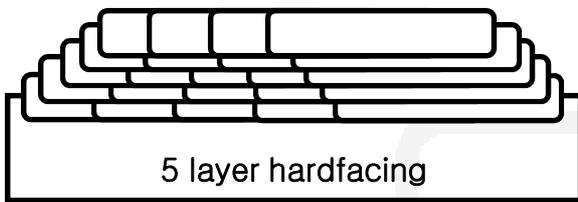
Supershield 410NiMo-O	Dia.	2.4mm(3/32in) 2.8mm(7/64in)
	Coil	25kg(55lbs)
	Pailpack	150kg(330lbs), 250kg(551lbs)



Supershield 410NiMo-O

Mechanical Properties & Chemical Composition of All Weld Metal

❖ Welding Conditions



Diameter	: 2.4mm(3/32in)
Welding Type	: Open Arc
Amp./ Volt.	: 380 / 28
Stick-Out	: 25~30mm(0.98~1.18in)
Pre-Heat	: 150~250℃(302~482°F)
Interpass Temp.	: 200~300℃(392~572°F)
Total layers	: ≥4 layer

❖ Chemical Analysis of All weld metal(wt%)

Consumable	C	Si	Mn	Cr	Ni	Mo	Nb
Supershield 410NiMo-O	0.04	0.85	1.05	14.45	3.90	0.65	0.26

❖ Hardness test of All weld metal(HRc)

Consumable	Hardness(HRc)					Avg.
Supershield 410NiMo-O	38	40	41	41	43	41

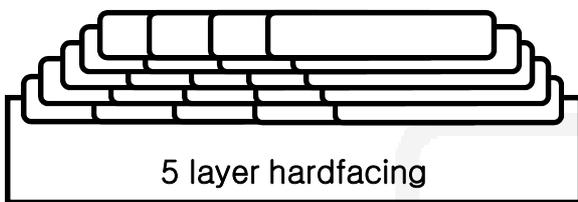
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Supershield 410NiMo-O

Mechanical Properties & Chemical Composition of All Weld Metal

❖ Welding Conditions



Diameter	: 2.8mm(7/64in)
Welding Type	: Open Arc
Amp./ Volt.	: 380 / 29
Stick-Out	: 25~30mm(0.98~1.18in)
Pre-Heat	: 150~250°C (302~482°F)
Interpass Temp.	: 200~300°C (392~572°F)
Total layers	: ≥4 layer

❖ Chemical Analysis of All weld metal(wt%)

Consumable	C	Si	Mn	Cr	Ni	Mo	Nb
Supershield 410NiMo-O	0.05	1.07	1.30	14.85	4.43	0.60	0.25

❖ Hardness test of All weld metal(HRc)

Consumable	Hardness(HRc)					Avg.
Supershield 410NiMo-O	40	40	41	42	42	41

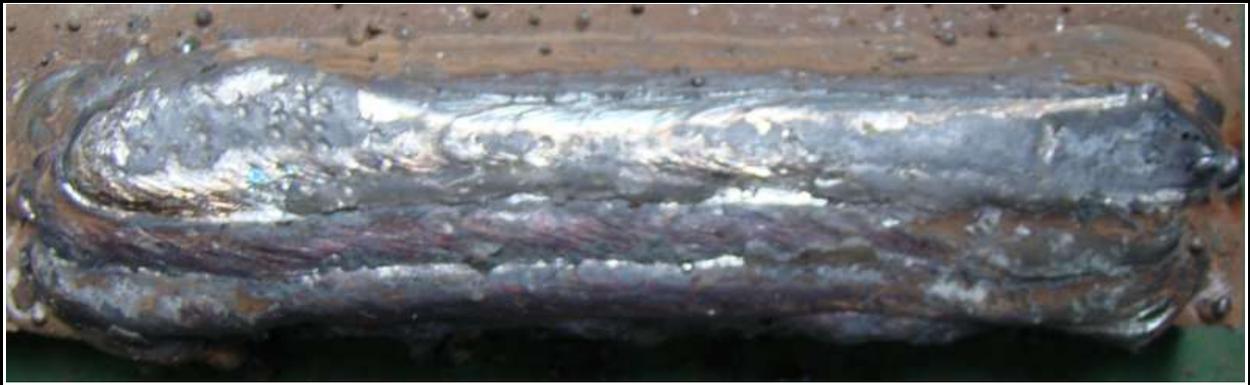
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Test Results

❖ BEAD APPEARANCE

Consumable	Supershield 410NiMo-O (2.4mm, 3/32in)
Amp.(A)	360~380
Volt.(V)	27~28
Carrige Speed	40~60cm/min(15.7~23.6in/min)
Welding Position	Flat(1G)



Consumable	Supershield 410NiMo-O (2.8mm, 7/64in)
Amp.(A)	370~390
Volt.(V)	27~29
Carrige Speed	40~60cm/min(15.7~23.6in/min)
Welding Position	Flat(1G)



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