

Supershield 410NiMo-0

Martentic STS Type

Conformances

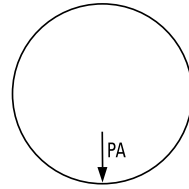
Applications

- Continuous casting rolls, steel mill rolls

Features

- Open arc type hardfacing wire
- Martensitic stainless steel type

Welding Position



Current

DC +

Welding Process

Open Arc

Diameter / Packaging

Diameter mm (in)	Coil		Pac
	25kg (55lbs)	150kg (330lbs)	250kg (551lbs)
2.4 (3/32)	✓	✓	✓
2.8 (7/64)	✓	✓	✓

Typical Chemical Composition of All-Weld Metal (%)

	C	Si	Mn	Cr	Ni	Mo	Nb
As welded with 2.4/2.8mm wire	0.05	0.7	0.9	13.0	4.0	0.5	0.2

Typical Mechanical Properties of All-Weld Metal

	Rockwell Hardness(HRC) (≥3layers)
On Mild Steel (2.4/2.8mm)	36-40

Typical Welding Parameters

Diameter, Polarity Shielding Gas	CTWD mm (in)	Wire Feed Speed m/min (in/min)	Amp. (A)	Volt. (V)	Deposition Rate kg/hr (lb/hr)
2.8mm (7/64in), DC+					
Open Arc	25 (1)	2.9 (114)	330	27	4.9 (10.8)
		3.3 (130)	360	29	5.5 (12.1)
		3.8 (149)	400	30	6.6 (14.5)