

CLASSIFICATIONS

EN ISO 14343-A : G/W 13

AWS A5.9 : ER 410

DESCRIPTION

- Preferred use in formation of surfaces resistant to corrosion, wear, and heat.
- Maintained hardness at temperatures of up to 500°C
- Resistance to formation of oxide layers at temperatures up to 900°C
- Required use of Ar+ %2.5 O₂ or Ar+ %2.5 CO₂ mixed gas as shielding gas
- For TIG; Ar gas as shielding

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL)

C: 0.10 | Si: 0.35 | Mn: 0.50 | Cr: 13.0

MECHANICAL PROPERTIES

Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (L ₀ =5d ₀) (%)	Heat Treatment
min. 250	min. 520	min. 20	840 °C - 870 °C/2h

BASE MATERIALS

- X 6 CrTi 17, X 20 CrNi 17 2, 431, 430 Ti
- AISI: 431, 430Ti

WELDING POSITIONS



CURRENT CONDITION

MIG D.C. (+) / TIG D.C. (-)

OPERATING DATA

Product Code	Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
1011100068	1.0	0.040"	15	BS 300
1011100069	1.2	0.047"	15	BS 300
1011100070	2.40 x 1000	3/32 x 39"	5	Plastic Box