

FOR STAINLESS STEEL

AWS ER410
JIS Y410

M-410

Typical applications

Welding of martensite stainless alloys of the 13%Cr types (STS 403, 410)
The alloy is suitable for the first layer of corrosion resistant weld claddings.

Typical chemical composition of wire (%)

C	Si	Mn	Ni	Cr
0.02	0.34	0.39	—	12.80

Typical mechanical properties of all-weld-metal

Shielding Gas	T · S N/mm ² {kgf/mm ² }	El (%)	Remark
Ar+2%O ₂	540 {55}	35	PWHT:745℃ × 1hr

Package

Dia. (mm)	0.8	0.9	1.0	1.2	1.4	1.6
Spool. (kg)	5, 12.5, 20					
Pailpack.(kg)	200, 250			200, 250, 300		

Approved by