



GMAW / GTAW STAINLESS STEEL

MIGINOX 410 / TIGINOX 410

12% Cr TYPE STAINLESS STEEL SOLID WIRE



CLASSIFICATION : AWS A/SFA 5.9

ER410

KEY FEATURES :

- Typical 12Cr type stainless steel wire
- Air hardenable weld deposit
- Preheat and PWHT recommended
- Resist corrosion, erosion & abrasion
- Smooth operating characteristics
- Radiographic quality welds

WELDING POSITION :



GMAW: DCEP
GTAW: DCEN

Shielding Gas	Gas Flow Rate, LPM	Stickout, mm
GMAW: 98Ar/2O ₂ or Ar/1-5CO ₂	15-22	10-20
GTAW: Ar	10-15	-

TYPICAL APPLICATIONS :

- Welding of similar composition 410 type steels and 13% Cr stainless steels
- Overlay application on carbon steel
- Surfacing of turbine blades, high pressure valves

STORAGE / HANDLING :

Keep dry and follow handling instructions mentioned on the box

CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt% :

	C	Mn	Si	Cr	Ni	Mo	S	P
Specification	0.12 max	0.6 max	0.5 max	11.5-13.5	0.6 max	0.75 max	0.03 max	0.03 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	EL%
Specification	PWHT:740°C for 1 hr	520 min	20 min

Mechanical properties will vary with the type of shielding gas used.

PACKING DATA :

Miginox 410	Ø, mm		Kg/Spool	
		1.2		12.5
	1.6		12.5	
Tiginox 410	Ø x L, mm	Primary Box, Kg	No. of Primary Boxes	Net Wt. of Carton, Kg
	1.6 x 1000	5	4	20
	2.0 x 1000	5	4	20
	2.5 x 1000	5	4	20
	3.2 x 1000	5	4	20