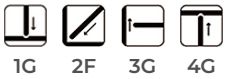
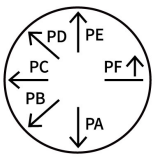
SW-410 Cored

Classification

AWS AWS A5.22/ ASME SFA-5.22 E410T1-1/-4
JIS Z 3323 TS410-FB1

Welding Positions





Features

- Weld metal of martensite stainless steel
- Good hardness and anti-abrasion properties

Polarity

DC +

Application Areas

- 410, 410S, 405 stainless steels
- Welding of ASTM CA6NM castings

Shielding Gas

100% CO2
Ar+20~25% CO2

Typical Chemical Composition of All-Weld Metal (wt%)

Shielding Gas	C	Si	Mn	P	S	Cu	Ni	Cr	Mo
100% CO2	0.06	0.5	0.4	0.008	0.008	0.03	0.4	12.5	0.01
Ar + 20% CO2	0.07	0.5	0.5	0.006	0.010	0.03	0.4	12.5	0.01

Typical Mechanical Properties of All-Weld Metal

Shielding Gas	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
100% CO2	600 (87)	22	0 (32)	14 (10)
Ar + 20% CO2	620 (90)	23	0 (32)	16 (11)

Diameter / Welding Parameters / Packaging

Wire Diameter mm(in)	Current (A)	Packaging
1.2 (0.045)	260~300	Spool 5kg(11lbs), 12.5(27.6lbs), 15kg(33lbs)
1.6 (1/16)	300~340	