



AWS A5.9: ER410
ISO 14343-A-2009 13

Stainless Steel Solid Wire

TIG Welding

SW-410

DESCRIPTION & APPLICATION

TIG Filler wire for the joining and overlay of Stainless Steels of similar composition (Straight Chrome) Martensitic deposit, which is heat treatable. Can be used to repair Plastic mould steels of similar composition.

BASE MATERIALS

AISI 410/420
ASTM A743 Gr CA15

MECHANICAL PROPERTIES

~650 UTS n/mm	>450 YIELD 0.2%	~18 ELONG A5%	300* HARDNESS HV	*As per heat treatment
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METAL WELD COMPOSITION %

C	Si	Mn	Cr	Ni	Mo	S	P	Fe
0.1	0.35	0.5	13	0.3	0.1	0.02	0.025	BAL

PACKAGING

5kg Tubes (TIG)

DIAMETERS

1.6, 2.4, 3.2mm (TIG)

WELDING INSTRUCTIONS

Shielding gas 100% Argon. Preheat to 200-300°C depending on component thickness and geometry, maintain interpass temperature above 150°C Slow cool in vermiculite or similar.