

DESCRIPTION

Executive 410 provides superior weldability, low spatter and smooth beads with easy slag removal. Weld metal is suitable for welding AISI 410 and AISI 420 types of stainless steel.

This 12 Cr alloy is an air-hardening steel. Preheat and postheat treatments are required to achieve welds of adequate ductility for many engineering purposes. The most common application of these electrodes is for welding alloys of similar compositions. They are also used for surfacing of carbon steels to resist corrosion, erosion or abrasion.

APPLICATIONS & FEATURES

Maintains excellent oxidation and corrosion resistance at high temperature. Obtains high hardenability after welding. Suitable for applications in petro-refining and chemical industries.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Si	Mn	P	S	Cr	Ni	Mo	Cu
0.019	0.54	0.29	0.031	0.007	13.32	0.20	0.04	0.05

Tensile Strength:	74,000 PSI min	Yield Strength:	46,400 PSI min	Elongation:	28%
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TYPICAL WELDING PARAMETERS

Process	Diameter	Length	Amperage
SMAW AC/DC	3/32"	12"	40-70
	1/8"	14"	60-100
	5/32"	14"	90-140
	3/16"	14"	120-185

STANDARD PACKAGING & HANDLING

SMAW	40-lb master box
	10-lb plastic tube

CLASSIFICATION

AWS/SFA 5.4, Class **E410-16**

