



S. R. Industries

STAR ARC ER410

ER410 is used to weld types 403, 405, 410, and 416 grades of stainless. It is also commonly used for welding overlay on carbon steels to resist corrosion, erosion, or abrasion. Because this is an air hardening type of material the joint to be welded should be preheated to 350°F.

AWS Specification : AWS A5.9/A5.9M:2006

AWS Classification	ER410
<i>Welding Current</i>	<i>DCEP</i>
Typical Wire Chemistry	
<i>C</i>	<i>0.12</i>
<i>Cr</i>	<i>11.5 - 13.5</i>
<i>Ni</i>	<i>0.6</i>
<i>Mo</i>	<i>0.75</i>
<i>Mn</i>	<i>0.6</i>
<i>Si</i>	<i>0.5</i>
<i>P</i>	<i>0.03</i>
<i>S</i>	<i>0.03</i>
<i>Cu</i>	<i>0.75</i>
Typical Mechanical Properties (As Welded post heat treatment between 1350° and 1400° F for one hour)	
<i>Yield Strength, ksi</i>	<i>78</i>
<i>Tensile Strength, ksi</i>	<i>89</i>
<i>Elongation%, min</i>	<i>24</i>
<i>Welding Positions</i>	<i>F,V,OH,H</i>

Address : C-617, DSIIDC, Narela, Delhi-110040 India

Tel : 011 47506585 **Mobile :** + 91 9911166585

E.Mail : srindus@yahoo.com

Website : www.stararc.in



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<i>Available Diameters MIG with Operating Range in Amps</i>	
<i>.030"</i>	<i>50 - 100</i>
<i>.035"</i>	<i>160 - 210</i>
<i>.045"</i>	<i>180 - 250</i>
<i>Available Diameters TIG with Operating Range in Amps</i>	
<i>.035"</i>	<i>60 - 90</i>
<i>.045"</i>	<i>80 - 110</i>
<i>1/16"</i>	<i>90 - 130</i>
<i>3/32"</i>	<i>120 - 175</i>
<i>1/8"</i>	<i>150 - 220</i>
<i>5/32"</i>	<i>170 - 350</i>

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