

GM 410



SOLID WIRE FOR MIG WELDING

SPECIFICATION :AWS/SFA 5.9: ER410 JIS:Z 3321 - Y410

CHARACTERISTICS :

GM 410 is low carbon solid MIG wire depositing martensitic stainless steel weld metal. The deposited weld metal is resistant to corrosion, oxidation and hydrogen attack.

TYPICAL USES :

Welding of stainless steel grade 410, 403, CA 15 (Cast) or SUS 403, 410.

Surfacing carbon -manganese steel, low alloy steel, stainless steel etc.

Chemical, Petrochemical, Refineries etc

COMPOSITION OF THE WIRE (RANGE) %:

C	Mn	Si	S	P	Cr	Ni	Mo	Cu
0.08 max	0.6 max	0.25-0.50	0.02 max	0.03 max	11.5-13.5	0.40 max	0.50 max	0.50 max

MECHANICAL PROPERTIES OF THE WELD METAL (RANGE) (AFTER PWHT) 850°C/2hrs

Ultimate Tensile StrengthMPa	0.2% Proof StressMpa	Elongation(%)(L=4D)	Charpy V-notch impact	
			Temp	Value
540-720	340-500	25-35	20°C	80 J

SHIELDING GAS: Argon + 2% Oxygen.

PACKING DATA :

SIZE (mm)	PACKING PER SPOOL, KG
0.8	12.5 Kg
1.00	12.5 Kg
1.20	12.5 Kg
1.60	12.5 Kg