

## XP ER 410

STAINLESS STEEL



### CLASSIFICATIONS

EN ISO 14343-A	AWS A5.9
G 13	ER410

### KEY FEATURES AND APPLICATIONS

- Solid welding wire of 13% Cr type.
- Primarily used to weld stainless steels of similar composition, and for applying corrosion, erosion, and abrasion-resistant overlays to carbon steels.
- The carbon content allows the weld metal to air-harden into a mostly martensitic microstructure.
- Preheating and post-weld heat treating are crucial steps to get welds with the right ductility for numerous engineering projects.
- Typically used on applications for heat furnaces and turbine part production.

### BASE MATERIALS

1.4000, 1.4001, 1.4002, 1.4003, 1.4006, 1.4008, 1.4021, 1.4024  
 X6Cr13, X6CrAl13, X10Cr13, X15Cr13, X20Cr13, G-X10Cr13  
 AISI 410, 420

### CHEMICAL COMPOSITION OF WIRE %

	C	Si	Mn	P	S	Cr	Ni	Mo	Cu
MIN	-	-	-	-	-	12.0	-	-	-
MAX	0.15	1.0	1.0	0.03	0.02	15.0	0.5	0.5	0.75

Single values are maximum values according to EN ISO 14343

### MECHANICAL PROPERTIES OF ALL-WELD METAL - TYPICAL (MIN.) VALUES

Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)
390 (≥250)	590 (≥450)	22 (≥15)

Test data for mechanical properties are not guaranteed since actual as welded conditions depend on numerous variables

### OPERATING DATA

Shielding Gases	Polarity
EN ISO 14175 - M12, M13	DC+

### PACKAGING AND AVAILABLE SIZES

Part Number	Diameter (mm)	Spool	Weight (kg)	Pallet Qty
XP30274	0.8	BS300	15	72
XP30276	1.0	BS300	15	72
XP30278	1.2	BS300	15	72