

SUNWELD 410

Stainless Steel Electrode



CLASSIFICATION

AWS A 5.4 : E 410-16

CHARACTERISTICS

A stainless steel electrode with air hardening type deposit, containing approximately 12.5% Chromium, consisting of fine ferrite containing martensitic structure. The weld metal is resistant to cavitations, abrasion, corrosion and oxidation. The weld deposits give the hardness of 350 to 375 BHN. Operates equally well on AC or DC (+) in all conventional positions.

HARDNESS

As Welded : 300-370 BHN
After S.R. at 720°C 1 1/4 hours : 430 BHN

APPLICATIONS

For overlap on unalloyed steels and heat treatable chromium steel castings having 13% to 15% Cr. Surfacing of several parts of turbine made of 13% Cr steels, Valve sheets and propeller shafts.

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL):

C	Mn	Si	Cr	Ni	Mo	Cu	S	P
0.072	0.85	0.65	12.20	0.54	0.60	0.75	0.019	0.017

MECHANICAL PROPERTIES OF ALL WELD METAL (TYPICAL)

Ultimate Tensile Strength	Elongation (GL=4d)
620.0 N/mm ²	34.2 %

CURRENT RANGE & PACKING DATA:

Size (mm)	Length (mm)	Current(Amp) AC or DC(+)	Quantity of Electrodes in a Carton	Quantity of Electrodes in a Cardboard box
3.15	350	90-130	2 Kg	10 Kg
4.00	350	140-180	2 Kg	10 Kg
5.00	350	180-220	2 Kg	10 Kg

RECOMMENDATIONS:

Re-dry the electrodes at 200°C for one hour. Keep the arc as short as possible. Weaving width should be within 2.5 times diameter of electrodes. Do not use excessive current.