

GEN 410 Welding Wire and Rod

GEN 410 is primarily used for welding stainless steel types 405, 410, 414 and 416. It is also used for an overlay on carbon steels for corrosion as well as abrasion resistance.

CONFORMANCES

AWS A5.9/A5.9M	:	ER 410
ASME SFA-A5.9	:	ER 410
UNS	:	S41080

AWS CHEMICAL COMPOSITION (TYPICAL)

%C	%Cr	%Ni	%Mo	%Mn
0.12	11.5 – 13.5	0.60 max	0.75 max	0.60 max
0.10	12.5	0.24	0.23	0.45

%Si	%P	%S	%Cu
0.50 max	0.03 max	0.03 max	0.75 max
0.38	0.023	0.002	0.15

TYPICAL WELD METAL MECHANICAL PROPERTIES

Tensile Strength	:	90,000 psi	620 MPa
Yield Strength	:	78,000 psi	538 MPa
Elongation (min.)	:	20 %	

TYPICAL WELDING PARAMETERS

Process	Diameter	Voltage	Amperage	Gas/Flux
TIG (GTAW)	1/16"	14 – 16	80 – 110	100% Ar
	3/32"	15 – 20	90 – 130	100% Ar
MIG (GMAW)	.035"	29 – 33	160 – 180	98%Ar – 2%O ₂
	.045"	29 – 33	180 – 220	98%Ar – 2%O ₂
Sub Arc (SAW)	.093"	28 – 32	250 – 450	
	.125"	29 – 34	300 – 500	

*All parameters are suggested as basic guidelines only and will vary depending on joint design, number of passes and other factors.

IMPORTANT: SPECIAL VENTILATION AND/OR EXHAUST REQUIRED
BEFORE USE, READ AND UNDERSTAND THE SAFETY DATA SHEET (SDS) FOR THIS PRODUCT AND SPECIFIC INFORMATION PRINTED ON THE PRODUCT CONTAINER.

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