


Technical data sheet <small>011121MBA</small>	Cored welding wire CHROME CORE 410-S	 Welding Alloys
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CLASSIFICATION

EN 14700: T Fe7
ASME IIC SFA-5.9 / AWS A5.9: EC410 (with higher Mn and Si)

DESCRIPTION

- Tubular cored wire for submerged arc hardfacing
- 13% chromium martensitic stainless steel deposit
- Deposit resists corrosion, erosion and abrasive wear

APPLICATIONS

- Hardfacing of continuous casting rolls, steam turbine components, centrifugal pump impellers, valve seats, valve gates, valve wedges, safety valves etc.

TYPICAL ALL-WELD METAL ANALYSIS [%]

C	Mn	Si	Cr
0.11	0.9	0.8	13

Structure: martensite + ferrite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-layer deposit: 40 - 43 HRC

FLUX DESCRIPTION

	WA FLUX 325	WA FLUX 385	WA FLUX 415	WA ULTRAFLUX
EN ISO 14174 class	S A AB 1 65	S A AF 2 64	S A FB 1 55	S A FB 1 55

OPERATING CONDITIONS

Diameter [mm]	Current [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
2.4	200 - 450	350	26 - 30	30	25 - 40	30
2.8	250 - 550	400	28 - 32	30	25 - 40	30
3.2	300 - 650	500	28 - 32	32	25 - 40	30

Recovery: 95%

Current type/polarity: DC+, DC-, AC

WELDING POSITIONS

Flat

PACKAGING

Diameter	≥ 2.4 mm	
Standard packaging	B 450 coil	Drum
Weight	25 kg	Up to 330 kg

Other packaging and other diameters: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.