



AMA 30-22T

AWS/ASME SFA-5.9

ER 410

DESCRIPTION:

Stainless steel welding wire rod for TIG welding . The nominal composition (wt %) is 12 Cr, and the all-weld metal microstructure is nearly fully martensitic. It is also used for deposition of overlays on carbon steels to resist corrosion, erosion, or abrasion.. The weld metal is an air-hardening steel. Preheat and postweld heat treatments are required to achieve welds of adequate ductility for many engineering purposes.. The preheat temperature is 150-250 °c and the heat treatment temperature (PWHT) is suggested to be 680-760 °c considering the specifications and working conditions. Weld metal and heat affected zone (HAZ) before heat treatment (PWHT) have low toughness and ductility.

Analysis of wire electrode:

C	Si	Cr	Mn	Ni	Mo	P	S	Cu
max0.12	Max0.5	11.5-13.5	Max0.6	Max0.6	Max0.75	max0.03	max0.03	Max0.75

Shielding gas: 100% Ar

TYPICAL APPLICATIONS :

Repair of rolling and continuous casting rollers, Power Generation , Power Plant ,Turbines

Diameter (mm)	Weight (kg)	Length (mm)
1 mm	5	1000 mm
1.2 mm	5	1000 mm
1.6 mm	5	1000 mm
2 mm	5	1000 mm
2.4 mm	5	1000 mm
3.2 mm	5	1000 mm
4 mm	5	1000 mm