

Stainless Steel SMAW Electrodes

G410

AWS A5.4 E410-16
JIS Z 3221 ES410-16
ISO 3581-A-E 13 R 1 2

Product Features:

- Martensite structure weld metal, self-hardening and good magnetism at room temperature.
- Good oxidation and corrosion resistance.
- 840~870°C Post Weld Heat treatment to improve ductility and good corrosion resistance.

Applications:

- Suitable for welding of 13%Cr martensite stainless steels such as SUS410, 420J, 420J2.

Typical chemical composition of all weld metal (wt%)

C	Si	Mn	Cr	Fe
0.10	0.23	0.30	11.6	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %
454	583	21

Size (mm) & recommended welding parameters (A) AC or DC+

Diameter / Length	2.6/300	3.2/350	4.0/350	5.0/350
Flat position	60~85	85~120	115~150	150~200
Vertical / overhead position	50~75	75~105	95~130	----

Note:

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