

Stainless Steel MIG•TIG Wire/Rod

GM410 / GT410

AWS A5.9 ER410
JIS Z 3321 YS410
ISO 14343-A-G 13
14343-A-W 13

Product Features:

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

Applications:

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

Shielding gas:

- Ar+ 1~2% O₂ (MIG)
- 100%Ar (TIG)

Typical chemical composition of wire / rod (wt%)

C	Si	Mn	Cr	Fe
0.10	0.40	0.35	11.53	Bal.

Typical mechanical properties of all weld metal

Tensile Strength N/mm ²	Elongation %	Post Weld Heat Treatment (PWHT)
630	39	850°C × 2hr

MIG Size (mm) & recommended welding parameters; DC+

Diameter (mm)	0.9/1.0	1.2	1.6
Current range (Amp)	70~200	90~250	200~300

TIG rod size diameter/length; DC-

Diameter (mm)	1.6	2.0	2.4/2.6	3.2
Length (mm)	1000	1000	1000	1000

Note:

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