

# Stainless Steel Flux Cored Wire

## GMX410

AWS A5.22 E410T1-1/4  
A5.22M E410T1-1/4  
JIS Z 3323 TS410-FB1  
ISO 17633-A-T 13 P C1 1, M21 1

### Product Features:

- GMX410 is especially developed for out-of-position welding.
- The smooth weld metal transfer and easy slag removal eliminates unnecessary clean up.
- The weld bead is uniform, flat to slightly concave and free from porosity.
- Penetration is complete and easy to obtain the flat equal.

### Applications:

- This alloy is used for corrosion and oxidation resistance especially for cavitation, generally for welding type of 403, 410, 420 steel, because of its martensite structure, it also could provide good heat resistibility and wearing resistibility and be hardfacing on various rollers for steel mills.

Typical chemical composition of all-weld metal (wt%)

C	Si	Mn	Ni	Cr	Mo	Fe
0.04	0.42	0.45	0.08	12.07	0.04	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation %
466	562	23

Size (mm) & recommended welding parameters

Diameter		1.2mm	1.6mm
Polarity		DC+	DC+
Ampere (A)	Flat / Horizontal position	140~220	200~280
	Vertical up position	90~130	----
Shielding Gas		CO <sub>2</sub> /80%Ar+20%CO <sub>2</sub>	CO <sub>2</sub> /80%Ar+20%CO <sub>2</sub>

### Note:

- Normally, keep preheat and layer temperature between 200 to 350 degree C.

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