

EXCALIBUR® 410-16

Stainless • AWS E410-16



KEY FEATURES

- Preheat and interpass temperatures greater than 400°F (200°C) are recommended during welding
- Great for overlay on carbon and low alloy steels

CONFORMANCES

AWS A5.4/A5.4M: 2012

E410-16

ASME SFA A5.4:

E410-16

TYPICAL APPLICATIONS

- Surfacing Steel Mill Rolls
- Furnace and Burner Parts
- Turbine Parts
- Welding 410 and 410s Stainless Steels

WELDING POSITIONS

All, except vertical down

DIAMETERS / PACKAGING

Diameter		Length		10 lb (4.5 kg) Easy Open Can
in	(mm)	in	(mm)	30 lb (13.6 kg) Master Carton
1/8	(3.2)	14	(355)	ED035012
5/32	(4.0)	14	(355)	ED035013
3/16	(4.8)	14	(355)	ED035014

DEPOSIT COMPOSITION(1)

	%C	%Cr	%Ni	%Mo	%Mn
Requirements					
AWS E410-16	0.12 max	11.0 - 13.5	0.7 max	0.75 max	1.0 max
Typical Results(2)	0.08	12.2	0.2	0.01	0.7
	%Si	%P	%S	%Cu	
Requirements					
AWS E410-16	0.90 max	0.04 max	0.03 max	0.75 max	
Typical Results(2)	0.40	0.02	0.003	0.06	

TYPICAL OPERATING PROCEDURES

Polarity(5)	Current (Amps)			
	3/32 in (2.4 mm)	1/8 in (3.2 mm)	5/32 in (4.0 mm)	3/16 in (4.8 mm)
AWS E410-16				
DC+/AC	40 - 80	75-110	95 - 150	130 - 200