

## Filler rod and wire

<b>Features:</b>	▪ Suitable for 13%Cr stainless steel
<b>Classification:</b>	AWS A5.9 ER410
<b>Shielding gas:</b>	Ar
<b>Identification color:</b>	1st Purple
<b>Polarity:</b>	DCEN

## Packaging data

φ mm	Spool	Tube		
	kg	kg	Length mm	g/piece
1.2	10	-	-	-
1.6	-	5	1,000	16
2.0	-	5	1,000	25
2.4	-	5	1,000	36
<b>Volume mm</b>	240W, 110H, 240L	40W, 35H, 1015L		

## Composition (rod and wire mass%)

	Typical	Guaranty <sup>a</sup>
<b>C</b>	0.10	0.12
<b>Si</b>	0.3	0.5
<b>Mn</b>	0.5	0.6
<b>P</b>	0.01	0.03
<b>S</b>	0.01	0.03
<b>Ni</b>	0.4	0.6
<b>Cr</b>	12.8	11.5~13.5
<b>Mo</b>	0.50	0.75
<b>Cu</b>	<0.01	0.75

Note: <sup>a</sup>Single values are maximum.

## Welding parameters (A)

φ mm	
1.2	50~100
1.6	100~200
2.0	100~200
2.4	150~250

## All-weld mechanical properties

	Typical
<b>0.2%YS (MPa)</b>	520
<b>TS (MPa)</b>	660
<b>EI on 4d (%)</b>	25
<b>PWHT (°C×h)</b>	760×1, FC