



# MIGINOX 410

GMAW STAINLESS STEEL

AWS A/SFA 5.9 ER410

### CLASSIFICATION:

EN ISO 14343-A  
G 13

IS 5856  
ES 13

### KEY FEATURES:

- Typical 12Cr type stainless steel wire
- Air hardenable weld deposit
- Preheat and PWHT recommended
- Resist corrosion, erosion & abrasion
- Smooth operating characteristics
- Radiographic quality welds

### APPROVALS: CE

### TYPICAL APPLICATIONS:

- Welding of similar composition 410 type steels and 13% Cr stainless steels
- Overlay application on carbon steel
- Surfacing of turbine blades, high pressure valves



### TYPICAL CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt %:

C	Mn	Si	Cr
0.04	0.5	0.4	12.5

### MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Typical	PWHT:740°C for 1 hr	750	22

### PARAMETERS - PACKING DATA:

Ø, mm	Kg/Spool		All Positions
1.2	12.5	 <b>DCEP</b> <b>STORAGE / HANDLING :</b> Keep dry and follow handling instructions mentioned on the box	
1.6	12.5		

Shielding Gas	Gas Flow Rate, LPM
98Ar/2O <sub>2</sub> or Ar/1-5CO <sub>2</sub>	15-25