

INERTFIL 410

MIG-MAG Wires Stainless and Heat resistant steels

Inertfil 410L is a solid wire for welding 12%Cr steels (AISI 410). These are self- hardening steels and usually require pre-heating and stress relieving treatments in order to obtain adequate ductility. Upon request Inertfil 410 solid wire with carbon 0,08% max can be supplied.

| Classification | |
|----------------|--------------|
| AWS | A5.9: ER 410 |
| EN | 12072: G 13L |

| Approvals | Grades |
|-----------|--------|
|-----------|--------|

Analysis of all-weld metal (Typical values in %)

| C | Mn | Si | P | S | Cr | Ni | Mo | Nb | Cu | N | Ferrite |
|------|------|------|---------|---------|-------|----|----|----|----|---|---------|
| 0.03 | 0.40 | 0.50 | ≤ 0.030 | ≤ 0.020 | 13.50 | - | - | - | - | - | - |

All-weld metal Mechanical Properties

| Heat Treatment | Yield Strength N/mm ² | Tensile Strength N/mm ² | Elongation A5 (%) | Impact Energy ISO - V (J) 20°C | Hardness |
|-----------------|-------------------------------------|---------------------------------------|----------------------|--------------------------------------|----------|
| PWHT 750°C x 1h | ≥ 350 | ≥ 450 | ≥ 20 | ≥ 47 | - |

Gas test: Acc. To EN 439: M13(Cargal1)

Shielding Gas: Acc. To EN 439: M13(Cargal1)

Materials

1.4000 (X6Cr13); 1.4006 (X12Cr13)

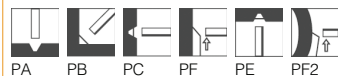
AISI 410

Storage

Keep dry and avoid condensation.

Current condition and welding position

DC+



Packaging data: BS300 Kg. 15

| | | | | | | |
|-----------|-----|-----|--|--|--|--|
| Diameters | 1,0 | 1,2 | | | | |
|-----------|-----|-----|--|--|--|--|