



## **EWB<sup>®</sup> – ER 410**

### **MIG / TIG Welding Wires**

#### **Classifications:**

EN ISO 14343-B:2007 : SS 410  
AWS A5.9: ER410

Material No. 1.4009

#### **Typical Chemistry Composition of Weld Deposit:**

C	Cr	Ni	Mo	Mn	Si
<0.12	11.50 – 13.50	<0.60	<0.75	<0.60	<0.50

#### **Description:**

- MIG / TIG welding of 12%Cr martensite stainless steels. (AISI STS 403, 410)

#### **Typical Mechanical Properties:**

Yield Strength (Mpa)	Tensile Strength (Mpa)	Elongation (%)
min. 250	min. 520	min. 20

#### **Welding Parameters:**

Wire Diameter (Ø in mm)	0.80	1.00	1.20
Pulsed Arc (A)	100 - 150	120 - 200	140 - 220
Voltage (V)	22 - 27	24 - 28	24 - 28

#### **Packing Available:-**

**MIG/MAG Wire** (Ø in mm): 0.80 / 1.00 / 1.20

**TIG Wire** (Ø in mm): 1.60 / 2.40 / 3.20 / 4.00

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#### **EWB Weld**

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