Technical data sheet 011121MBA	Cored welding wire # CHROMECORE 410-S	Welding Alloys

CLASSIFICATION

EN 14700: T Fe7
ASME IIC SFA-5.9 / AWS A5.9: EC410 (with higher Mn and Si)

DESCRIPTION

- Tubular cored wire for submerged arc hardfacing
- 13% chromium martensitic stainless steel deposit
- Deposit resists corrosion, erosion and abrasive wear

APPLICATIONS

- Hardfacing of continuous casting rolls, steam turbine components, centrifugal pump impellers, valve seats, valve gates, valve wedges, safety valves etc.

TYPICAL ALL-WELD METAL ANALYSIS [%]

C	Mn	Si	Cr
0.11	0.9	0.8	13

Structure: martensite + ferrite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-layer deposit: 40 - 43 HRc

FLUX DESCRIPTION

	WA FLUX 325	WA FLUX 385	WA FLUX 415	WA ULTRAFLUX
EN ISO 14174 class	S A AB 1 65	S A AF 2 64	S A FB 1 55	S A FB 1 55

OPERATING CONDITIONS

Diameter [mm]	Current [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
2.4	200 - 450	350	26 - 30	30	25 - 40	30
2.8	250 - 550	400	28 - 32	30	25 - 40	30
3.2	300 - 650	500	28 - 32	32	25 - 40	30

Recovery: 95%
Current type/polarity: DC+, DC-, AC

WELDING POSITIONS

Flat

PACKAGING

Diameter	≥ 2.4 mm	
Standard packaging	B 450 coil	Drum
Weight	25 kg	Up to 330 kg

Other packaging and other diameters: please consult us