M-410

For martensite stainless steel (Low Carbon,12%Cr STS)

Classifications

EN ISO 14343-B:2009	: SS 410	JIS Z 3321:2013	: YS410
AWS A5.9-2012	: ER410	KS D 3696:2006	: STSY410

Description

- MIG welding of 12%Cr martensite stainless steels. (AISI STS 403, 410)
- It's used for surfacing of sealing faces of valves for gas, water and steam piping system at service temperatures up to 450℃

Typical chemical composition of wire (%)

C	Si	Mn	Ni	Cr
0.01	0.32	0.36	0.19	12.61

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	Remark
AWS A5.9		min. 520	min. 20	
EN ISO 14343	min. 250	min. 450	min. 15	PWHT
Example	320	540	35	

* PWHT : Heat to 730~760℃, for 1h, Furnace cooling down to 315℃, then air cooling