

WAAM solid wire, high-alloyed, ferritic martensitic stainless steel

Material Type						
AISI 410						
Characteristics						
WAAM solid wire of 13% Cr 4% Ni type designed for 3Dprinting processes. Optimised for good ductility and crack resistance.						
Typical analysis of the solid wire (wt.-%)						
	C	Si	Mn	Cr	Ni	Mo
wt.-%	0.01	0.65	0.7	12.2	4.8	0.5
Available products						
Diameter: 1,0 mm – 1,2 mm						
Package: BS300 15 kg – ECOdrum 100 – ECOdrum 250 – S760 300						
Other diameters and packages on request.						
Typical mechanical properties acc. to EN ISO 15792-1						
Heat treatment	Yield strength R _{p0,2}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact energy ISO-V KV J		
	MPa	MPa	%	+20°C	-20°C	
u	950	1210	12	36		
a	760 (≥ 500)	890 (≥ 750)	17 (≥ 15)	80	≥ 47	
u	untreated, shielding gas Ar + 8 – 10% CO ₂					
a	annealed, 580°C/8 h / furnace down to 300°C / air – shielding gas Ar + 8 – 10% CO ₂					
Classification as welding consumable:						
EN ISO 14343-A			AWS A5.9			
G 13 4			ER410NiMo(mod.)			