



FCW 410

Flux Cored Wire

Classification

AWS A5.22 : E410 T 0-4
EN ISO 17633-A : T 13R M3

EN 14700 : T Fe7

Characteristics

Rutile flux cored wire to weld with shielding gas protection used for cladding and for joining of 410 stainless steels. Nice bead appearance, self releasing slag, good penetration and high productivity.

Applications

To Surface valve seats and to weld Ferritic martensitic stainless steels used in the presence of sulphurous gas. Forged & Cast Steels.

Base Materials

UNS	Alloy	EN	Material N°	UGINE
S 41000	410	X12Cr13	1.4006	
S 41008	410S	X6Cr13	1.4000	UGINOX F 13 S
S 42000	420	X20Cr13	1.4021	
		X15Cr13	1.4024	

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	P	S	Fe
0.05	0.60	1.00	12.00	0.40	0.015	0.005	base

All Weld Metal Mechanical Properties (Typical)

Conditions	UTS R _m (MPa)	YS R _{p0.2} (MPa)	% Elg A ₅
PWHT	500	300	25

PWHT : After heat treatment at 760°C/1hr and air cooled to Room Temp.

Welding Current & Instructions

Welding Mode	Ø Wire (mm)	Welding Mode			Shielding Gas ISO 14175
		Current (A)	Voltage (V)	Stick-out (mm)	
FCAW = +	1.2	120 - 250	23 - 30	15 - 20	M21 (Ar+10-20 %CO ₂) or CO ₂ 18 - 20 l/min

Preheating : 200°C ; Interpass temperature : 200 - 300°C

Welding Positions : 1G/PA ; 2G/PC ; 1F ; 2F/PB

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