

MI 410

Gazaltı (MIG/MAG) Kaynak Teli - Stainless Steels

Standards

AWS/ASME SFA - 5.9	ER 410
EN ISO 14343 - A	G 13
TS EN ISO 14343 - A	G 13
DIN M. No.	1.4006

Materials

Width	Material
X6Cr13	1.4000
X12Cr13	1.4006
X20Cr13	1.4021

Properties and Applications

Martensitic stainless steel wire for GMA (MIG/MAG) welding of martensitic stainless steels, heat resistant steels and cast steels which contain approx. 13% chromium. Suitable for joining and surfacing of gas, water and steam fan, fan blades and fittings subjected to corrosion, erosion and operating temperatures up to 450°C. Depending on type of base metal composition and thickness, preheating between 200 and 300°C, keeping the interpass temperature during welding and tempering between 700 and 750°C after welding are advisable. Stick Electrode : EIS 410TIG Welding Rod: TI 410



Typical Chemical Features of the Welding Wire

Type of Analysis	C	Si	Mn	Cr	Cu
Welding Wire	0.10	0.30	0,50	12.50	0,50

Typical Mechanical Values of Weld Metal

Test Condition	Protection Gas	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Charpy V-Notch Properties (J)	
Isıl İşlem Sonrası (760°C 1 Saat)	M12	450	600	23	20°C → 60	0°C → 30

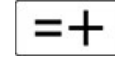
* Chemical composition and mechanical properties are valid when using shielding gas .

Application Information

Welding Positions



Polarity:



Protection Gas:

M13 M12 M14 I1

Welding Parameters & Efficiency

Diameter (mm)	
	0.80
	1.00
	1.20
	1.60

Packaging Information

Product Code	Diameter (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
23010BJAM2	0.80	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)
23010DJAM2	1.00	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)
23010EJAM2	1.20	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)
23010GJAM2	1.60	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)

Storage & Re-Drying Information

Shouldn't be exposed to high statical load and impact.
It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.