



Manufacturers of Custom Welding Lines for Resale
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SELECTRODE
1410
Grey 410-15

INTERNATIONAL CLASSIFICATIONS

AWS/ASME A5.4: E410-15
EN 1600: E Z 13 B 42

FEATURES & APPLICATIONS

This electrode is used for joining similar composition stainless and cast steels with 13% chromium. This alloy is used extensively for corrosion and oxidation resistance at elevated temperatures up to 1500°F. Unlike the chromium-nickel stainless steels, this type is not subject to loss of corrosion resistance due to carbide precipitation. It is also used for the surfacing of carbon steels to resist abrasion, erosion and corrosion. It is a air hardened steel which requires preheat and post heat treatment to achieve welds of adequate ductility.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Flux Color: Grey

| C | Cr | Ni | Mn | Si | S | P |
|-----|-------|-----|-----|-----|-----|-----|
| .08 | 12.70 | .40 | .80 | .32 | .02 | .02 |

TYPICAL MECHANICAL PROPERTIES

| Undiluted Weld Metal | Maximum Value Up to: |
|-----------------------------|-------------------------------------|
| Tensile Strength | 79,000 PSI (545 N/mm ²) |
| Elongation | 22% |
| Hardness | 350 HB |

WELDING CURRENT & INSTRUCTIONS

Recommended Current: DC Reverse (+)

| Diameter (mm) | 3/32 (2.5) | 1/8 (3.25) | 5/32 (4.0) | 3/16 (5.0) |
|------------------|------------|------------|------------|------------|
| Minimum Amperage | 60 | 90 | 110 | 150 |
| Maximum Amperage | 90 | 120 | 160 | 190 |

Welding Techniques: Clean weld surfaces to remove all scale and corrosion. Maintain a short arc gap and use stringer bead technique.

Welding Positions: Flat, Horizontal, Vertical-Up and overhead