

DESCRIPTION

Executive 410 wire is designed to provide clean and consistent welds with excellent feedability and minimal clean-up. By maintaining tight control from the country of melt to the design of the spool Executive wire provides welders with the highest quality stainless bare wire.

Executive 410 is an air-hardening steel of 12% Cr (nominal composition). Preheat and post weld heat treatments are required to achieve welds of adequate ductility for many engineering purposes.

APPLICATIONS & FEATURES

Executive 410 is used for surfacing steel mill rolls, furnace, burner and turbine parts.

Executive 410 is also used for deposition of overlays on carbon steels to resist corrosion, erosion, or abrasion.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

| C | Cr | Ni | Mo | Mn | Si | P | S | Cu |
|------|-------|------|------|------|------|-------|-------|------|
| 0.08 | 12.58 | 0.28 | 0.05 | 0.44 | 0.30 | 0.024 | 0.002 | 0.03 |

Tensile Strength: 78,300 PSI min **Yield Strength:** 49,300 PSI min **Elongation:** 25%

TYPICAL WELDING PARAMETERS

| Process | Diameter | Voltage | Amperage | Gas Flow | Shielding Gas / Flux | |
|---------------------|---------------|-----------------------------|----------|--------------|---|---------|
| GMAW - Short | .035" | 21-22 | 160-200 | 30 to 50 CFH | 90% He/7.5% Ar/2.5% CO ₂ or 1%-5% O ₂ /Balance Ar | |
| | .045" | 22-23 | 180-210 | | | |
| | .062" | 23-24 | 200-220 | | | |
| | - Spray | .035" | 23-25 | | | 190-260 |
| | | .045" | 25-28 | | | 250-330 |
| | | .062" | 28-31 | | | 310-350 |
| GTAW | .062" - .125" | Direct Current; Electrode - | | 30 to 40 CFH | 100% Ar | |
| SAW | .093" | 29-32 | 300-350 | | Record IND 24 or Record IN | |
| | .125" | 29-32 | 400-550 | | | |

STANDARD PACKAGING

| | | |
|-------------------|----------------------|-----------------|
| GMAW (MIG) | 33-lb wire baskets | 1,980-lb pallet |
| | 11-lb plastic spools | 11-lb box |
| | 2-lb plastic spools | 8-lb box |
| GTAW (TIG) | 10-lb plastic tube | 40-lb box |
| SAW | 60-lb wire coil | 1,200-lb pallet |

CLASSIFICATION

AWS/SFA 5.9, Class **ER410**

