

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 - Spray	.035"	21-22	160-200	30 to 50 CFH	98% Ar / 2% O ₂
	.045"	22-23	180-210		
	.035"	23-25	190-260		90% Ar / 10% O ₂
	.045"	25-28	250-330		
GTAW	.093"	Direct Current; Electrode -		30 to 40 CFH	100% Ar
SAW	.093"	29-32	300-350		Record IN Flux
	.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**