

CWR-410 Welding Wire and Rod

CWR-410 is primarily used for welding stainless steel types 405, 410, 414 and 416. It is also used for an overlay on carbon steels for corrosion as well as abrasion resistance.

CONFORMANCES

AWS A5.9/A5.9M	:	ER 410
ASME SFA-A5.9	:	ER 410
ISO 14343-B	:	SS410

AWS CHEMICAL COMPOSITION (TYPICAL)

%C	%Cr	%Ni	%Mo	%Mn
0.12	11.5 – 13.5	0.60 max	0.75 max	0.60 max
%Si	%P	%S	%Cu	Total Others
0.50 max	0.03 max	0.03 max	0.75 max	0.50 max

TYPICAL WELD METAL MECHANICAL PROPERTIES

Yield Strength	:	78,000 psi
Tensile Strength	:	90,000 psi
Elongation (min.)	:	20 %

TYPICAL WELDING PARAMETERS

Process	Diameter	Voltage	Amperage	Gas/Flux
TIG (GTAW)	1/16"	14 – 16	80 – 110	100% Ar
	3/32"	15 – 20	90 – 130	100% Ar
MIG (GMAW)	.035"	29 – 33	160 – 180	98%Ar – 2%O ₂
	.045"	29 - 33	180 – 220	98%Ar – 2%O ₂
Sub Arc (SAW)	.093"	28 – 32	250 – 450	
	.125"	29 - 34	300 – 500	

*All parameters are suggested as basic guidelines only and will vary depending on joint design, number of passes and other factors.

<p>IMPORTANT: SPECIAL VENTILATION AND/OR EXHAUST REQUIRED</p> <p>BEFORE USE, READ AND UNDERSTAND THE SAFETY DATA SHEET (SDS) FOR THIS PRODUCT AND SPECIFIC INFORMATION PRINTED ON THE PRODUCT CONTAINER.</p>

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