



FW 410

CODIFICATION: AWS : SFA 5.9 ER410

CHARACTERISTICS AND APPLICATIONS:

FW 410 is a solid wire for TIG welding, available in bright finish, gives smooth flow, stable arc and spatter free under optimum welding conditions. It gives radiographic quality weld deposit. Weld metal possesses excellent resistance to corrosion, pitting, abrasion, and impact. It is suitable for joining of similar alloys and for surfacing and overlay applications on unalloyed steels. Ideally suited for surfacing of valves and other components of turbine, steam valves made of 13Cr steel, etc.

TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

Element	C	Mn	Si	S	P	Cr
%	0.06	0.5	0.40	0.025	0.025	12.0

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

(PWHT : 740°C for one Hour)

UTS (MPa)	Elongation (L = 4d) %
550	23.0

SHIELDING GAS: Argon

CURRENT CONDITIONS: DCEN

WELDING POSITIONS: H, F, VU, OH

PACKING:

STANDARD SIZE: Diameter 1.6 mm, 2.0 mm, 2.4 mm & 3.2 mm in cut lengths of 1000 mm each.

QUANTITY 5 kgs wire put in an air-tight polythene bag and finally packed in a plastic container.
Identification – AWS code is punched on each wire.