

Gas Metal Arc Welding

MS M-410 Solid Wires for Stainless Steel

Applications Suitable for welding of 405,410,410S stainless steel is an air-hardening steel. Preheat and posheat treatments are required to achieve welds of adequate ductility for many engineering purposes.

Brand Name		MS M-410							
Representative of diameter (mm)	0.8	0.9	1.0	1.2	1.6	-	-	-	-
Chemical composition of wire (%)	C	Si	Mn	P	S	Ni	Cr	Mo	-
	≤ 0.12	≤ 0.50	≤ 0.6	≤ 0.03	≤ 0.03	≤ 0.6	11.5-13.5	-	-
Mechanical property of deposited metal									
Tensile strength	≥ 450 N/mm ²								
0.2% Offset strength	-								
Elongation	≥ 20 %								
Impact test	NA								
Welding position	Horizontal/Flat position								
Welding polarity	DC-EP								
Shielding gas	98%Ar - 2%O ₂								
Welding current	Dia.0.8 mm	Dia.0.9 mm	Dia.1.0 mm	Dia.1.2 mm	Dia.1.6 mm				
	80-180A	120-200A	140-250 A	170-300 A	200-350A				
Packing	12.50 kgs standard other packing weight can be provided upon request.								