

# Gas Tungsten Arc Welding

JIS Z3321 Y410  
 AWS A5.9 ER410  
 DIN 8556-SG 1.4009

## MS T-410 Filler Rod 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 T-410							
Representative of diameter (mm)	1.0	1.2	1.6	2.0	2.4	2.6	3.2	4.0	5.0
Representative of length	1000 mm Standard or 950 mm Upon requested								
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	≤ 0.75	-
Mechanical property of deposited metal									
Tensile strength	≥ 450 N/mm <sup>2</sup>								
0.2% Offset strength	-								
Elongation	≥ 20 %								
Impact test	2mm Vnotch Impact value at 20° C 210J								
Welding position	All position								
Welding polarity	DC-EN								
Shielding gas	Ar								
Welding current	Dia. 1.2 mm		Dia. 1.6 mm			Dia. 2.4 mm			
	30-80 A		40-120 A			50-150 A			
Packing									
Inner case weight (kg)	5.00								