Inweld 410-16

AWS A5.4 E410-16

Chemical Composition of Inweld 410-16

Fe	C	Cr	Ni	Mo	Mn	Si	P	S	N	Cu
Balance	0.08	12.70	0.40	---	0.80	0.32	0.02	0.02	---	---

Single values are maximum unless otherwise specified.

Description and Applications

This electrode is used for joining similar composition stainless and cast steels with 13% chromium. It is also used for the surfacing of carbon steels to resist abrasion, erosion and corrosion. 410 is a air hardened steel which requires preheat and postheat treatment to achieve welds of adequate ductility. Flat, Horizontal, vertical up and overhead. Clean weld surfaces to remove all scale and corrosion. Maintain a short arc gap and use stringer bead technique.

Typical Weld Metal Properties

	AWS Spec
Tensile Strength:	118,000 psi
Yield Strength:	
Elongation:	22%

Recommended Parameters

SMAW (DCEP – Electrode+)

Wire Diameter	Voltage	Amperage
3/32”		60-90
1/8”		90-120
5/32”		110-160
3/16”		150-190