

MIGINOX 410 / TIGINOX 410

Classification

AWS A/SFA 5.9 : ER 410

Characteristics

This filler is used for MIG welding of straight chrome stainless steels of 13% Cr content. As the weld is of air hardening type, both pre-heating and post-weld heat treatments are required.

Typical Applications

For welding of stainless steels represented by AISI types 403, 405, 410 etc. Joining sections of steel armatures, pump parts and oil refinery equipments.

Typical Wire Chemistry

C	Mn	Si	Cr	S	P	Ni
0.12 max	0.60	0.50 max	11.5-13.5	0.030 max	0.030 max	0.6 max

Properties of weld metal with 98% Ar + 2% O₂ gas Current Condition : DC (+) in GMAW

All Weld Mechanical Properties As welded condition

UTS MPa	530
Elongation % (L=4xd)	23
The chemistry & mechanical properties of the weld will vary with the type of shielding gas used.	

Packing Specifications

Supplied in D 300 plastic spools - layer wound / Weight - 12.5 Kg

Packing Specifications for MIGINOX 410

	2.0	1.6	1.2	0.80
	12.5	12.5	12.5	12.5

Each plastic spool is sealed in a polyethylene bag and then packed in a corrugated box which is shrink-wrapped.

for TIGINOX 410

Dia., mm	1.0	1.2	1.6	2.0	2.5
Length,mm	1000	1000	1000	1000	1000
Net wt per tube,kg	5	5	5	5	5
No of Plastic Tubes per Box	4	4	4	4	4
Net wt,Box,kg	20	20	20	20	



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