

Classification **AWS A5.4 : E410-16**

**Description and applications**

Heavy coated semi basic rutile type MMA electrodes suitable for the welding of 11-13.5% Cr Steels (AISI 410) Ferritic Martensitic Chrome Steels. These steels are air hardening type and therefore pre-heating and stress relieving treatments are required to obtain a suitable ductility to allow mechanical working.

**Base materials**

1.4000 (X6Cr13); 1.4006 (X12Cr13)  
AISI 410

**Typical Weld Metal Chemical Composition(%)**

C	Mn	Si	P	S	Cr	Ni
0.07	0.50	0.40	0.02	0.010	12.00	0.50

**All weld metal Mechanical Properties (Typical)**

Stress Relieved (PWHT)	Yield strength $R_p(N/mm^2)$	Tensile strength $R_m(N/mm^2)$	Elongation $A_5 (%)$
PWHT 760°C for 1hr	≥ 250	≥ 520	≥ 22

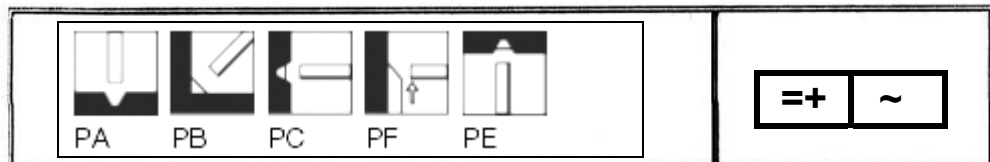
**Amperes (A)**

2.50m	3.15m	4.00m	5.00m
60 – 90	90 – 140	140 – 180	190 – 240

**Welding instruction**

Keep dry and avoid condensation.  
Re-dry at 280-300°C for 1 hour, 3 times max

**Welding positions**



**Stellaris Specialities India Ltd.**

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