

Select 410

Description:

Select 410 is a gas-shielded, flux cored, stainless steel electrode designed for single or multipass welding in the flat and horizontal positions. It contains 12% Cr. The weld deposit is air hardening and is normally heat-treated after welding. It is designed for use with either 100% carbon dioxide or a blend of 75-80% argon/balance carbon dioxide .

Classification:

- E410T0-1, E410T0-4 per AWS A5.22

Characteristics:

Select 410 provides superb performance characteristics. It has a smooth, stable arc, low spatter residue, easy slag peeling and produces smooth, well-washed beads.

Applications:

Select 410 is used to weld straight 410 stainless steel. It provides good corrosion and oxidation resistance up to 1200°F.

Typical Mechanical Properties(Ar-25%CO₂):

	<u>SR 1 Hr. at 1375° F</u>
Ultimate Tensile Strength (psi)	78,000
Yield Strength (psi)	45,000
Percent Elongation	24

Typical Deposit Composition:

<u>Shielding Gas</u>	<u>C</u>	<u>Cr</u>	<u>Mn</u>	<u>Si</u>
75Ar/25CO ₂	.07	12.8	.70	.50

Typical Welding Parameters (CO₂):

<u>Diameter</u>	<u>Optimum</u>			<u>Range</u>	
	<u>Amperage</u>	<u>WFS</u>	<u>Voltage</u>	<u>Amperage</u>	<u>Voltage</u>
3/32"	425	180	29	300-550	26/34
1/16"	330	330	29*	150-400	22-34
.045"	350	450	28*	130-300	21-32

* Decrease by 1 volt when using Ar-25% CO₂.

Rev 0 (03/12/2014)

Notice: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. Thus the results are not guarantees for use in the field. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.