

Shield-Bright 410

AWS A5.22 E410T1-1(4) / JIS Z3323 TS410-FB1

Flux
CORED
WIRES

Description and Application

- Shield-Bright 410 is 13%Cr martensitic stainless steel flux cored wire. It is used for overlay welding on valve sheet surface because of its martensite structure in as welded condition which shows high hardness and wear resisting properties. It will be showed good ductility and excellent corrosion resistance after post-weld heat treatment at 600~850°C, and it is suitable for welding of AISI 410, 403, 420J1, and 420J2. Recommended for welding remove dirt such as oil and dust from the groove. Normally, pre-heat is necessary at 200~400°C.

Shielding Gas : 100%CO₂ or 75%Ar/25%CO₂

Typical Mechanical Properties of All Weld Metal(100%CO₂)

Yield Point N/mm ² {kgf/mm ² }	Tensile Strength N/mm ² {kgf/mm ² }	Elongation (%)	PWHT
430 {44}	580 {59}	26	750°C × 1hrs

Typical Undiluted Weld Metal Analysis %(100%CO₂)

C	Mn	Si	P	S	Cr
0.021	0.35	0.35	0.020	0.002	11.55