DW-410Cb PREMIARC™

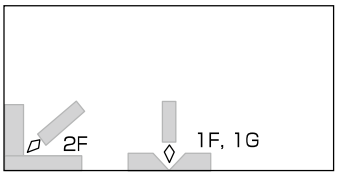
Flux cored wire

Features: ▪ Suitable for 13%Cr martensitic stainless steel such as 403 and 410 types and 13%Cr ferritic stainless steels such as 405 type

Classification: AWS A5.22 E409NbT0-1

Shielding gas: CO_2
Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Spool
1.2	12.5kg
Volume mm	295W, 110H, 295L

Composition (all-weld metal mass%)

	Typical (CO_2)	Guaranty [a]
C	0.05	0.10
Si	0.5	1.0
Mn	0.7	1.2
P	0.03	0.04
S	<0.01	0.03
Ni	0.1	0.6
Cr	12.6	10.5~13.5
Mo	<0.1	0.5
Cu	<0.1	0.5
Nb+Ta	0.64	8xC~1.5
Bi	>0.002	-

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F
1.2	130~270

All-weld mechanical properties

	Typical (CO_2)	Guaranty
0.2%YS (MPa)	282	-
TS (MPa)	515	449min.
El on 4d (%)	30	15min.
IV (J)	-	-
PWHT (℃xh)	775x2	760~790x2