



## WB410M M.I.G. WELDING WIRE

<b>Classifications</b>	AWS A5.9-81 : ER410      ~BSEN12072-00 : 13									
<b>Product Description</b>	Martensitic 410/ 13C stainless steel, solid MIG wire.									
<b>Applications</b>	WB410 MIG is used mainly for welding and repairing 410S21, 403S17, 410C21 etc. Widely used for turbines, valve bodies, pump casings, piping etc.									
<b>Wire Composition(Weight %)</b>	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	
<b>min.</b>	0.06	0.4	0.20	-	-	11.5	-	-	-	
<b>max.</b>	0.12	1.2	0.60	0.03	0.03	13.5	0.60	0.5	0.75	
<b>Typical All-Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength				N/mm <sup>2</sup>		690			
	Yield Stress/0.2% Proof Stress				N/mm <sup>2</sup>		520			
	Elongation on 5D				%		20			
	Impact Energy CV @ +20°C				Joules		<20			
	PWHT @ 740°C/1Hr									

<b>Wire Dia (mm)</b>		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
<b>Current Range (Amps)</b>	<b>min.</b>	-	-	-	150	180	200	300
	<b>max.</b>	-	-	-	250	300	300	400
<b>Volt Range (Volts)</b>	<b>min.</b>	-	-	-	20	22	22	25
	<b>max.</b>	-	-	-	28	30	28	32
<b>Packaging Information</b>								
<b>Kg Per Reel</b>		-	-	-	-	-	15	15
<b>Storage</b>	<b>Storage</b> It is recommended that the WB range of wires are stored in a dry heated store at a minimum temperature of 18°C, and a maximum relative humidity of 60%.							
<b>Gases</b>	<b>Gas</b> Pure Argon or Argon + 2%O <sub>2</sub> mixture  <b>Flow Rate</b> 12-16 l/min							

### Current Conditions DC+ and Welding Positions

