Standard: **AWS A 5.9** **YB/T5092**	Chemical Composition %								
	C	Mn	Si	Cr	Ni	P	S	Mo	Cu
Grade ER410	≤0.12	≤ 0.6	≤ 0.5	11.5 – 13.5	≤ 0.6	≤0.03	≤0.03	≤0.75	≤0.75
Type	Spool (MIG)				Tube (TIG)				
Specification (MM)	0.8、0.9、1.0、1.2、1.6、2.0				1.6、2.0、2.4、3.2、4.0、5.0				
Package	S100/1kg S200/5kg S270,S300/15kg-20kg				5kg/box 10kg/box length :1000MM				
Diameter （MM）	0.8	1.0	1.2	1.6	2.0	2.5	3.2		
Current （A）	70 ~ 150	100 ~ 200	140 ~ 220	50 ~ 100	100 ~ 200	200 ~ 300	300 ~ 400		
Application	ER410 is also called H12Cr13.The main component is 13Cr. it is martensitic stainless steel MIG wire, which can be welded in all position. There was little splash. It is often used in water power station and valve, such as 12Cr13SUS41010. It can be used to weld 410 or 420 series stainless steel. It has high hardening property and high temperature oxidation resistance. Corrosion resistance, used in oil scouring and chemical industry and surfacing repair.								
Notice	1. Oil, dirt and rust on the welding wire surface should be removed before welding. Surface impurities such as oil, rust and water should be thoroughly removed in the welding place, so as to prevent blowhole, crack and so on during welding. The surface of the groove and its surroundings should be polished with metallic gloss. 2. In order to obtain good mechanical properties of welding seam, suggest protect gas Ar+2%O2 and shield gas flow rate 20-25 L/min for MIG welding. For TIG welding,suggest protect gas pure Ar and shield gas flow rate 8-15 L/min ,Arc length 1～3 mm; Length of the tungsten pole is about 3～5 mm; wind speed limit ≤ 1.0 m/s， argon protection at the back of welding area . 3. In the welding process, the welding line energy directly affects the mechanical properties and crack resistance of weld metal, and should be paid more attention to. 4. The above welding methods, conditions and specifications are for reference only. Users should evaluate the welding process according to their own welding characteristics before using the welding wire for the formal product welding.								