Selectarc WELDING

FCW 410LP

Flux Cored Wire

Classification

AWS A5.22 : E410 T1-1/4

EN ISO 17633-A : T 13P M1 / C1

Characteristics

Rutile flux cored wire to weld in all positions with shielding gas protection used for cladding and for joining of 410 stainless steels. Nice bead appearance, self releasing slag, good penetration and high productivity.

Applications

To Surface valve seats and to weld Ferritic - Martensitic stainless steels used in the presence of sulphurous gas.

Base Materials

UNS	Alloy	EN	Material N°	UGINE
S 41000	410	X12Cr13	1.4006	
S 41008	410S	X6Cr13	1.4000	UGINOX F 13 S
S 42000	420	X20Cr13	1.4021	
		X15Cr13	1.4024	

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	P	S	Fe
0.05	0.60	1.00	12.00	0.40	0.015	0.005	base

All Weld Metal Mechanical Properties (Typical)

Conditions	UTS R_m (MPa)	YS $R_{p0.2}$ (MPa)	% Elg A_5
PWHT	500	300	25

PWHT : After heat treatment at 760°C/1hr and air cooled to Room Temp.

Welding Current & Instructions

Welding Mode	Ø Wire (mm)	Welding Mode			Shieding Gas
		Current (A)	Voltage (V)	Stick-out (mm)	ISO 14175
FCAW = +	1.2	120 - 250	23 - 30	15 - 20	M21 (Ar+10-20 %Co_2) or CO_2 18 - 20 l/min

Preheating : 200°C ; Interpass temperature : 200 - 300°C

Welding Positions : 1G/PA ; 2G/PC ; 3G/PF ; 2F/PB

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