MIG M13/0

Old reference: MIG 410

Classification

ISO 14343-A : G 13
AWS A5.9 : ER410

Material N° : 1.4009

Description & Applications

Solid wire electrode for surfacing of valves as well as for joining stainless steels (403, 405, 416…). Resistant to atmosphere corrosion, water corrosion and light acids. Used for piping systems with maximal temperature service at 450°C.

Typical Chemical Composition (%)

C	Si	Mn	Cr	P	S	Fe
0.03	0.3	0.5	13.1	<0.03	<0.02	Rem.

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)
250	450	15	+20°C 90
After PWHT 750°C/2h			

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG = +	0.8 1.0 1.2 1.6	100-150 120-200 140-220 180-260	22-27 24-28 24-28 24-30	EN 439 : M1 Ar + 2%CO_2 18-20 l/min

For massive parts, preheating is advised at 200-300°C.

Ind.10

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