TIG M13/0

Old reference: TIG 410

Classification

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

Material N° : 1.4009

Description & Applications

Solid rod for TIG welding stainless steels (403, 405, 416…). Resistant to atmosphere corrosion, water corrosion and light acids.
Mainly applied in welding and hardfacing of piping systems, working at service temperature < 450°C.

Typical Chemical Composition (%)

C	Si	Mn	Cr	P	S	Fe
0.10	0.3	0.5	13.0	<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 at 750°C/2h

Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	Ar : 6-12 l/min Back shielding : Argon / Nitrogen : 3-6 l/min

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