

## MIDALLOY CHROMAX E410-16 COATED ELECTRODE

### Classification

- AWS 5.4 Class E410-16 ASME SFA 5.4 Class E410-16 ASME Sec. IX, F4, A6

### DESCRIPTION

- MIDALLOY CHROMAX E410-16 is an AC-DC titania coated electrode
- UNS W41010

### APPLICATION

- For welding or repairing alloy hardenable stainless steels like types 410, 416, 420, 431 and cast C-15.
- Overlay of carbon and low alloy steels for resistance to corrosion, erosion, or abrasion.
- E410-16 has higher hardness and is used in valve seats to obtain better galling resistance.

### TYPICAL CHEMISTRY

C	Cr	Ni	Mo	Mn	Si	P	S	Cu	Fe
.09	12.3	0.45	0.25	0.55	0.30	.020	.010	.10	BAL.

**RECOMMENDED: PREHEAT TEMPERATURE**                      **400 °F**  
**INTERPASS TEMPERATURE**                                      **600 °F**  
**POST WELD HEAT TREATMENT**                                      **1,350 °F TO 1,400 °F**

### TYPICAL MECHANICAL PROPERTIES (PWHT 1,375°F for 1 hr.)

<b>TENSILE STRENGTH</b>	80,500 PSI
<b>YIELD STRENGTH</b>	44,500 PSI
<b>ELONGATION IN 2"</b>	24%

### RECOMMENDED WELDING PARAMETERS

DIAMETER	AMPERAGE	
	FLAT	VERTICAL & OVERHEAD
3/32"	70-85	50-75
1/8"	85-125	80-90
5/32"	110-160	100-120
3/16"	120-200	110-130

### STANDARD PACKAGING

3/32" - 8 lb. Can, 48 lb. Carton

1/8", 5/32", 3/16" - 10 lb. Can, 60 lb. Carton

11/16/10

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