

TECH-ROD 410

I. **DESCRIPTION:** Tech-Rod 410 is designed to weld stainless steels of similar chemical composition as well as to overlay carbon steels to impart corrosion, erosion, and abrasion. This material, being, an air-hardening type, calls for a preheat and interpass temperature of not less than 400°F (200°C) during welding.

Note: Mechanical properties below reflect utilization of post-weld heat treatment between 1550°F and 1650°F for two hours.

II. **APPROVALS:** Manufactured under Quality System approved by ASME, ISO9001. Meets AWS 5.4 Class E410-16.

III. **CHEMICAL COMPOSITION**

Carbon	.12
Manganese	.68
Silicon	.52
Chromium	12.1
Nickel	25.2
Sulfur	.021
Phosphorus	.022
Iron	Balance

MECHANICAL PROPERTIES

Tensile Strength	
78,500 PSI	540 MPA
Yield Strength	
63,000 PSI	430 MPA
Elongation:	23%

IV. **WELDING PARAMETERS**

Direct Current
Electrode + Ve

AMPERAGES:

3/32"	65-75
1/8"	90-105
5/32"	120-135
3/16"	135-155

(For vertical welding amperages are to be reduced by 10 to 15 amps)

V. **PACKAGES AVAILABLE:**

3/16"-10# can, 5/32"-10# can, 1/8"-10# Can, 3/32"-8# can