

# Product Data Sheet

**BRAND NAME** VJ ER410

**AWS/ASME Class** ER410

**SPECIFICATION** SFA A5.9



## Features and Applications :

VJ ER410 is ideal for welding 403, 405, 410, 414, and 416 stainless steels, offering excellent corrosion, pitting, abrasion, and impact resistance. Suitable for joining similar alloys, surfacing, and overlay applications, including valves, turbines, and steam components made of 13Cr steel.

## CHEMICAL COMPOSITION :

All Weld Metal (%)			
TYPICAL	Max	TYPICAL	Max
C	0.10	Mn	0.60
Cr	12.50	Si	0.40
Ni	0.35	S	0.015
Mo	0.75	P	0.015
Cu	0.75		

## MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal - PWHT 740°C - 1 HR	
Properties	Typical
UTS (MPa)	560
El (%)	24

## DIMENSIONS:

Dimension (mm)	
GMAW	GTAW
0.80	1.6
1.20	2.0
1.60	2.4
	3.2

<b>GMAW CURRENT</b> : DC (+)	<b>SHIELDING GAS:</b>	ARGON
<b>GTAW CURRENT</b> : DCEN	<b>SHIELDING GAS:</b>	ARGON

## PACKING :

**GTAW** : 5 kg wire put in a plastic container. Identification AWS code is punched on side of wire.

**GMAW** : The wire can be supplied in plastic spool packed in a cardboard box weighing 15.0 kg.

## WELDING POSITION:

