

Solid Wire Electrode for Submerged Arc Welding

BA-WIRE 410

Classification: EN ISO 14343-A – S 13
SFA-5.9 – ER410

Typical analysis and chemical composition acc. to EN ISO 14343-A and AWS A5.9: (Weight Percent)

Wire electrode	C	Si	Mn	Mo	Ni	Cr	P	S	Cu total
Typical analysis BA-WIRE 410	0.10	0.4	0.4	0.2	0.1	13.0	0.015	0.015	0.2
S 13 acc. to ISO 14343-A	0.15	1.0	1.0	0.5	0.5	12.0–15.0	0.03	0.02	0.5
ER410 acc. to AWS A5.9	0.12	0.5	0.6	0.75	0.6	11.5–13.5	0.03	0.03	0.75

Application:

Wire electrode for submerged arc welding intended for welding 13 % chromium steels. Service temperatures up to +450 °C.

Base Materials:

- 1.4006 X12Cr13, 1.4021 X20Cr13
AISI 410, 420
Suitable fluxes: BF 38, WP 380

Flux type suitability is strongly dependent on its application. In combination with the wire electrode the most suitable flux should match the requirements of the plate material as closely as possible under the existing welding conditions. Further information can be obtained from the technical flux data sheets.

Package forms:

Coils, spools, drums and spiders as standard package forms for SAW-wire electrodes, different package forms on request.

Diameter:

1.6 – 4.0 mm; sizes and tolerances acc. to ISO 544 and AWS A5.9.

Wire electrode surface:

Smooth finish free from surface defects and foreign matter.