

RONOX-410

FERRITE STEEL CONTINUOUS & CUT LENGTH
SOLID WELDING WIRE FOR MIG/TIG WELDING

BASIC ALLOY: FE, CR,
AWS/SFA-A5.9: ER410
EN ISO 14343-A: G 13

KEY FEATURES:

RONOX-410 is a martensitic stainless steel that is heat-treatable. It has a nominal weld metal composition of 12% Chromium. These weld deposits are air-hardenable that can normally be heat treated after welding.

APPLICATIONS

- ER410 is a solid wire electrode for GMAW, suitable for welding 13% chromium steels, overlay carbon steels for improved corrosion, erosion and abrasion resistance. Service temperature up to +450 °C.

SHEILDING GAS:

- welding with 100% Ar gas Or Ar+2%O₂ gas

CHEMICAL COMPOSITION:

C	Mn	Si	S	P	Ni	Cr	Mo	Cu
0.12 max.	0.60 max.	0.50 max	0.030 Max	0.030 Max	0.60 max.	11.50-13.50	0.75 max	0.75 Max

MECHANICAL PROPERTIES:

UTS (N/mm ²)	Proof strength (N/mm ²)	EL % (l=5d)	CHARPY "V" NOTCH IMPACT @
450 min.	350 min.	17.00 min	+20C : 47 J min

WELDING POSITION



DIEMENSION, CURRENT CONDITION & PACKING DATA (FOR MIG WELDING)

Size (mm)	Size (inch)	Current Condition (DC+)	Voltage (V)	Gas Flow Rate L/min	Spool packing 12.5 kg	Spool packing 15 kg	Drum packing 100/200kg
0.80	0.031	70-220	16-24	10-20	✓	✓	X
1.20	0.047	150-300	24-34	15-25	✓	✓	✓
1.60	1/16"	150-350	28-36	15-30	✓	✓	✓

DIEMENSION, CURRENT CONDITION & PACKING DATA (FOR TIG WELDING)

Size (mm)	Size (inch)	Length (mm)	Length (Inch)	Current Condition (DC+)	Voltage (V)	Tube packing 5 kg	Box packing 20 kg
1.60	1/16"	1000	36"	40-80	10-16	✓	✓
2.0	5/64"	1000	36"	50-100	12-18	✓	✓
2.4/ 2.5	3/32"	1000	36"	60-120	14-20	✓	✓
3.2	1/8"	1000	36"	100-150	16-24	✓	✓
4.0	5/32	1000	36"	140-200	18-28	✓	✓