Unibraze 410-16

CLASSIFICATIONS: AWS A5.4/ASME SFA 5.4 Class E410-16 UNS W41010

DESCRIPTION: Unibraze 410-16 is an air hardened 12% Cr steel electrode for welding alloys of similar composition. It is used for surfacing of carbon steels to resist corrosion, erosion or abrasion.
Preheat and interpass temperature of not less than 400°F during welding and requires post-weld treatment to obtain required ductility. It has a smooth running arc that results in a uniform bead that is flat to slightly convex.

Typical Chemistry:

	C	Cr	Ni	Mo	Mn	Si	P	S	Cu
AWS/ ASME	.12 max	11.0 – 13.5	.70 max	.75 mas	1.0 max	.90 max	.04 max	.03 max	.75 max
Typical (As welded)	.08	12.0	.20	.01	.70	.40	.02	.01	.06

Typical Mechanical Properties

Tensile Strength	92,500 psi
Yield Strength	78,000 psi
Elongation	21 %

Typical Welding Parameters

Dia.	Amps Flat	Amps Vertical and Overhead
3/32”	70-90	60-85
1/8”	85-110	80-90
5/32”	110-140	100-120
3/16”	120-160	110-130