LINCOLN® ER410
Stainless • AWS ER410

KEY FEATURES
- Designed to weld stainless steels of similar chemical composition as well as to overlay carbon steels to impart corrosion, erosion and abrasion resistance
- This material, being an air-hardening type, calls for a pre-heat and inter-pass temperature of 400°F (200°C) or greater during welding
- Q2 Lot® - Certificate showing actual wire composition and calculated ferrite number (FN) available online
- Ink jet printing identification on entire length of electrode

WELDING POSITIONS
All

DIAMETERS / PACKAGING

<table>
<thead>
<tr>
<th>Diameter in (mm)</th>
<th>10 lb (4.5 kg) Tube</th>
<th>30 lb (13.6 kg) Master Carton</th>
</tr>
</thead>
<tbody>
<tr>
<td>1/16 (1.6)</td>
<td>ED035244</td>
<td></td>
</tr>
<tr>
<td>3/32 (2.4)</td>
<td>ED035245</td>
<td></td>
</tr>
<tr>
<td>1/8 (3.2)</td>
<td>ED035246</td>
<td></td>
</tr>
</tbody>
</table>

*Bulk packages available - Contact Lincoln Electric

WIRE COMPOSITION\(^{(1)}\) – As Required per AWS A5.9/A5.9M

| Requirements
AWS ER410 | %C | %Cr   | %Ni | %Mo | %Mn |
<table>
<thead>
<tr>
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<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>0.12 max</td>
<td>11.5 – 13.5</td>
<td>0.6 max</td>
<td>0.75 max</td>
<td>0.6 max</td>
<td></td>
</tr>
<tr>
<td>Typical Performance(^{(2)})</td>
<td>0.11</td>
<td>12.5</td>
<td>0.1</td>
<td>0.03</td>
<td>0.45</td>
</tr>
</tbody>
</table>

| Requirements
AWS ER410 | %Si | %P | %S | %Cu |
<table>
<thead>
<tr>
<th></th>
<th></th>
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<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>0.5 max</td>
<td>0.03 max</td>
<td>0.03 max</td>
<td>0.75 max</td>
<td></td>
</tr>
<tr>
<td>Typical Performance(^{(2)})</td>
<td>0.39</td>
<td>0.01</td>
<td>0.01</td>
<td>0.14</td>
</tr>
</tbody>
</table>

\(^{(1)}\)Typical all weld metal. \(^{(2)}\)See test results disclaimer

CONFORMANCES
AWS A5.9/A5.9M: ER410
ISO 14343: 2009: 13
ASME SFA-5.9: ER410

TYPICAL APPLICATIONS
- Surfacing Steel Mill Rolls
- Furnace and Burner Parts
- Turbine Parts

SHIELDING GAS
100% Argon

IMPORTANT: SPECIAL VENTILATION AND/OR EXHAUST REQUIRED
Fumes from the normal use of some welding products can contain significant quantities of components - such as chromium and manganese - which can lower the 5.0 mg/m\(^3\) maximum exposure guideline for general welding fume.

BEFORE USE, READ AND UNDERSTAND THE SAFETY DATA SHEET (SDS) FOR THIS PRODUCT AND SPECIFIC INFORMATION PRINTED ON THE PRODUCT CONTAINER.
CUSTOMER ASSISTANCE POLICY

The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers’ particular purpose is specifically disclaimed.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

Subject to Change – This information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.com for any updated information.

Material Safety Data Sheets (MSDS) and Certificates of Conformance are available on our website at www.lincolnelectric.com