BASINOX 410

TOP FEATURES

- Most common application of these electrodes is for welding alloys of similar compositions. They are also used for surfacing of carbon steels to resist corrosion, erosion, or abrasion.
- BASINOX 410 is also used for stainless wear resistant surfacing on unalloyed or low-alloy steels for the sealing surfaces of water, gas or steam fittings.
- Easy slag release
- Well-suited for positional welding.

CLASSIFICATION

AWS A5.4	E410-15*
EN ISO 3581-A	E Z 13 1 B 42
EN ISO 14700-A	E Fe10*

* Nearest classification

CURRENT TYPE

DC+

WELDING POSITIONS

All position, except vertical down

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	P	S	Cr	Ni
0.05	0.4	0.3	0	≤0.025	12	1.50

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	0.2% Proof strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) +20°C	Hardness (HB)
AWS A5.4	PWHT	not specified	≥520	≥20	not specified	not specified
EN ISO 3581-A	PWHT	not specified	≥520	≥15	not specified	not specified
Typical values	680°C x 8h	550	720	22	55	200

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 300	65-95
3.2 x 350	85-140
4.0 x 350	120-190

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5x300	VPMD	100	1.8	W000288022
3.2x350	VPMD	50	1.9	W000288023
4.0x350	VPMD	40	2.2	W000288024

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:

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