Stanvac® INTERNATIONAL

Product Data Sheet

STAVINOX 410-15

MMA Electrodes
Stainless & Heat Resistant Steels

Classification	
AWS	A5.4 : E 410-15
EN	1600 : E 13 B 32

Description: Heavy coated low hydrogen MMA electrodes suitable for the welding of 11 – 13.5% Cr Steels (AISI 410) Ferritic Martensitic Chrome Steels. These steels are air hardening and therefore pre-heating and stress relieving treatments are required to obtain a suitable ductility to allow mechanical working.

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
0.07	0.50	0.20	0.02	0.010	12.00	0.50	-	-	-	-	-

All-weld metal Mechanical Properties (Typical)

Heat Treatment	Yield Strength N/mm²	Tensile Strength N/mm²	Elongation A5 (%)
PWHT 760°C × 1h	≥ 250	≥ 520	≥ 22

Materials

1.4000 (X6Cr13); 1.4006 (X12Cr13)

AISI 410

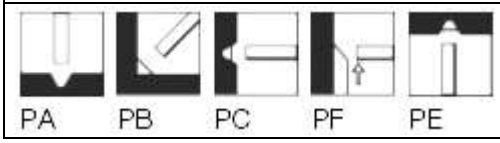
Storage and redrying

Keep dry and avoid condensation.

Re-dry at 280-300°C for 1 hour, 5 times max

Current condition and welding position

DC+; AC



Amperes

2.50mm	3.15mm	3.20mm	3.25mm	4.00mm	5.00mm
60 – 90	90 – 140	90 – 140	90 – 140	140 – 180	190 – 240

Special Characteristics

Hardness:	As welded	300 – 370 BHN
	After S.R.	170 – 220 BHN

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