

GFC 410

FLUX CORED WIRE

IDENTIFICATION

GFC 410, E410T1-1/4

CLASSIFICATION

AWS A5.22: E410T1-1/4, JIS Z3323: TS410-FB1

DESCRIPTION

GFC 410 is designed for MAG welding of martensite stainless alloys of the 13% Cr types and for surfacing of sealing faces of valves for gas, water, and steam piping system at service temperatures upto 450°C.

WELD METAL ANALYSIS (RANGE) %

C	Si	P	S	Mn	Cr	Mo	Ni
0.12 max	1.0 max	0.04 max	0.03 max	1.2 max	11.0 - 13.5	0.75 max	0.60 max

MECHANICAL PROPERTIES (RANGE)

Heat Treatment	UTS (MPa)	EL (%) (L=4D)
750°C / 1 h	520 min	20 min

TYPICAL APPLICATIONS

Suitable for the first layer of corrosion resistant weld claddings.

MICRO STRUCTURE : Martensite

SHIELDING GAS : 100% CO₂ or 80% Ar + 20% Co₂

PACKING PARAMETERS

Size (mm)	Weight / Spool (kg)
1.2	12.5