

TECHNICAL DATA

Standards

DIN Material Nr. 1.4009

EN ISO 14343-A :	G 13
AWS A5.9 :	ER410

General Properties / Field of Applications

DSI M 410 is a Pulse Laser Wire suitable for welding stainless steels with 12-14% Cr. Primarily used for sealing surfaces on fittings made of unalloyed or low-alloy steels for operating temperatures up to 450°C. The machinability of the weld metal largely depends on the degree of dilution. Outstanding sliding and feeding characteristics. Very good welding and flow behaviour. Color matching on joint welds of 13% Cr-steels of the same type, with very good polishing properties.

Mechanical Properties

Yield strength $R_{p0.2}$	[MPa] / [N/mm ²]	480 (annealed 720°C/2hr)
Tensile strength R_m	[MPa] / [N/mm ²]	630 (annealed 720°C/2hr)
Elongation A ($L_0 = 5d_0$)	[%]	22 (annealed 720°C/2hr)
Hardness	[HB]	180 at RT (annealed 720°C/2hr)
Hardness	[HB]	310 at RT (untreated, as welded)
Maximum operating temp.	[°C]	450

Chemical Composition (Standard Values in %)

C	Si	Mn	Cr
0.11	0.4	0.5	13.2

Compatible Materials (Selection)

Ferritic chrome steels as 1.4000 X7Cr13 / 1.4008 G-X12Cr14 / 1.4001 X7Cr14
1.4021 X20Cr13 / 1.4002 X7CrAl13 / 1.4024 X15Cr13 / 1.4006 X10Cr13

Packaging and available Sizes*

Spool : MA125 mm	Ø mm	0.2 / 0.3 / 0.4 / 0.5 / 0.6 / 0.7 / 0.8 / 1.0 / 1.2
Rod : 500 / 1000 mm	Ø mm	0.2 / 0.3 / 0.4 / 0.5 / 0.6 / 0.7 / 0.8 / 1.0 / 1.2

* Other dimensions available on request

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