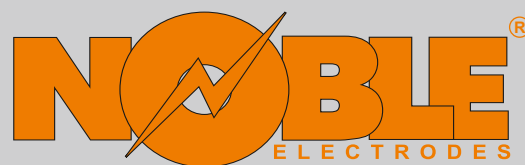


NOBLE - 410

Stainless Steel Electrodes



CLASSIFICATION

AWS - A5.4: E410-16

Characteristics : NOBLE - 410 is a titania type, all positional electrode which gives smooth weld bead and easily detachable slag. It is air hardening type electrode. It requires preheat to ensure ductility.

Applications : NOBLE - 410 is suitable for air hardening of similar chemical composition or to overlay carbon steel to prevent erosion, corrosion or abrasion. It is used for surfacing steel mill rolls, furnace and burner parts, turbine parts and valve sheets.

Mechanical Properties

Mechanical Tests	AWS Specifications
Tensile Strength	520 N/mm ² (Min.)
Elongation	20 % (Min.)

*If Moist: Re-dry at 250°C For 1 Hr.

Weld Metal Chemistry (%)

Elements	C	Mn	Si	P	S	Ni	Cr	Mo
Range	0.12 Max	1.0 Max	0.90 Max	0.04 Max	0.03 Max	0.70 Max	11 - 13.5	0.75 Max

Packing Specifications & Current Condition

Size (mm)	Pkts. / Case	Wt. / Pkt	Current (Amp.) AC (70V) DC (+)
3.15 x 350	05	2 Kg.	80 - 100
4.00 x 350	05	2 Kg.	100 - 135

“Noble – Characterized by all Excellent Qualities”