



Supplier of Welding Alloys

Stainless Steel Coated Electrodes

Oxford Alloy® 410-16

SPECIFICATIONS

AWS 5.4
ASME SFA 5.4

CLASSIFICATIONS

AWS E410-16
UNS W41010

DESCRIPTION / APPLICATION

Oxford Alloy E410-16 is an electrode designed to run on direct current, reversed polarity as well as alternating current. This electrode is an air hardening steel which requires preheat and post weld heat treatment to obtain the required ductility. The preheat and interpass temperature for work pieces 3/4 inch and under is 400 ° F. Work pieces over 3/4 inch thick should use a preheat and interpass of 500 ° F. The post weld heat treatment temperature is 1350-1400 ° F; the holding time should be 1 hour per inch of thickness but no less than 30 minutes. The temperature should be raised and lowered at a rate of 200 ° F per hour. The weld metal has similar corrosion resistance to that of the corresponding base metal. Oxford Alloy E410-16 has good scaling resistance but is prone to slow attack by certain acids.

AWS Chemical Composition						
C	Cr	Mn	Si	P	S	Ni
0.12 max	11.0-13.5	1.0 max	0.90 max	0.04 max	0.03 max	0.7 max
Mo	Cu					
0.75 max	0.75 max					

TYPICAL MECHANICAL PROPERTIES

Tensile strength: 78,735 psi 543 MPa
Yield strength: 46,400 psi 320 MPa
Elongation: 28%

Please contact our sales department for more information at 800-562-3355 or 225-273-4800.

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