

# TASETO Welding Materials

Stainless Steel Electrodes

For Flux Cored Arc Welding

## GFW410Cb

Applicable Specification  
JIS Z 3323 TS409Nb-FM0

### ● Applications and Characteristics

TASETO GFW410Cb is used for overlay welding of 13%Cr steel. As its all weld metal contains Nb, GFW410Cb provides fully ferritic weld metal with high ductility and free of quench hardenability. Delayed cracking is prevented with lower preheat and interpass temperature compared with martensitic steel weld metal such as Type 410 stainless steel.

### ● Notes on Usage

- \* Please refer “Guideline for Welding Stainless Steel with GFW Wires”.
- \* Keep the preheat and interpass temperature at 150°C to 250 °C and heat treat at 730°C to 760 °C after welding.
- \* Use Ar+20%CO<sub>2</sub> as shielding gas.

### ● Chemical Composition of All Weld Metal (%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu	Nb+Ta
Typical	0.066	0.54	0.18	0.027	0.004	0.08	13.04	0.02	0.03	0.86

### ● Mechanical Properties of All Weld Metal

	Heat Treatment	0.2% Proof Stress (MPa)	Tensile Strength (MPa)	5D Elongation (%)
Typical	750°C×1h AC	289	549	25.0

### ● Sizes Available and Shielding Gas

Size (mm)	Shielding Gas
1.2	Ar+20%CO <sub>2</sub> , 20L/min
1.6	Ar+20%CO <sub>2</sub> , 20L/min