

TASETO Welding Materials

Stainless Steel Electrodes

For Shielded Metal Arc Welding

RNY 4 1 0

● Applicable Specification

JIS Z 3221 ES410-16
AWS A5.4 E410-16

● Identification Color

End Face: Purple
Side Face: —

● Applications and Characteristics

TASETO RNY410 is used for filling cavities or joint welding of 13%Cr steel (Type 410, 405). It is also suitable for overlay welding for cavitation-erosion prevention purpose.

RNY410 is a lime-titania type electrode suitable for positional welding.

● Notes on Usage

* Dry the electrode at 150°C to 200°C for 60 minutes before use.

* Keep preheat and interpass temperature at 200°C to 400°C and apply PWHT at 730°C to 760°C at 1h after welding to avoid delayed cracking.

● Chemical Composition of All Weld Metal (%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
Typical	0.06	0.36	0.31	0.013	0.012	0.12	12.56	0.23	0.16

● Mechanical Properties of All Weld Metal (PWHT : 740°C × 1h, AC)

	Tensile Strength (MPa)	5D Elongation (%)
Typical	514	24.2

● Other Properties of All Weld Metal (Typical)

* 30% Nitric Acid Test : 3.5 g/m²·h (PWHT : 740°C × 1h, AC)

● Sizes Available, Recommended Currents (AC or DCEP)

Size (mm)	Length (mm)	Welding Current (A)	
		Flat	Vertical, Overhead
2.6	300	50~90	45~80
3.2	350	80~120	65~110
4.0	400	110~150	85~135
5.0	400	150~200	—