



## D&H 410

**CODIFICATION :** AWS : SFA 5.4 E410-26

### CHARACTERISTICS AND APPLICATIONS :

D&H 410 is a high deposition electrode designed for joining of similar alloys and for surfacing and overlay applications on unalloyed steels and chromium steel having 12.5Cr. The weld deposit displays good resistance to corrosion, erosion, pitting and abrasion. Ideally suited for surfacing of valves and other components of turbine, steam valves made of 13Cr steel, etc.

### TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

Element	: C	Mn	Si	Cr
Percent	: 0.08	0.70	0.6	12.5

**WELD METAL HARDNESS :** 370-400 VHN

### CURRENT AND PACKING DATA : AC / DC(+)

Size (mm)	: 5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	: 180-220	140-180	90-130	70-100
Weight/Carton (kgs)	: 2.5	2.5	2.5	2.5

### PRECAUTIONS :

1. Ensure the electrodes are dry. Redry moist electrodes at 250-300°C for one hour.
2. Use short arc and minimum heat input.