

Classifications					
EN ISO 14343-A	EN ISO 14343-B	AWS A5.9	Mat. No.		
G Z 13	SSZ410	ER410(mod.)	1.4009		
Characteristics and typical fields of application					
Stainless; corrosion-resistant similar to matching 13 % Cr(Ni) steels / cast steel grades. For surfacing applications with matching or similar 13 % Cr steels/cast steel grades. For surfacing sealing faces of water, steam and gas valves and accessories made of unalloyed and low-alloy steels/cast steel grades for service temperatures up to 450 °C (842 °F).					
Base materials					
1.4006 – X10Cr13; 1.4000 – X6Cr13; AISI 410, 420					
Typical analysis of solid wire (wt.-%)					
	C	Si	Mn	Cr	Ni
wt-%	0.08	0.9	0.65	14.0	0.4
<b>Structure:</b> Martensite with part ferrite, suitable for quenching and tempering					
Mechanical properties of all-weld metal					
Heat-treatment	Yield strength R <sub>p0.2</sub>	Tensile strength R <sub>m</sub>	Elongation A (L <sub>0</sub> =5d <sub>0</sub> )	Impact work ISO-V KV J	
	MPa	MPa	%	HB30	HRC
680 °C / 8 h (1256 °F)	450	650	15	180	
aw					35
Operating data					
<b>Polarity:</b> DC ( + )	<b>Shielding gas:</b> (EN ISO 14175) M12, M13		<b>ø (mm)</b> 1.0 1.2	<b>Spool:</b> B300 B300	
Welding instruction					
Materials	Preheating	Postweld heat treatment			
Surfacing: martensitic Cr steels / cast steel grades	Acc. to wall thickness: 200 – 400 °C (392 – 752°F)	Cooling to around 120 °C (248 °F), then tempering or quenching and tempering			
Surfacing: unalloyed / low-alloy steels / cast steel grades	Larger wall thickness: 100 – 200 °C (212 – 392°F)	None; if necessary tempering to required hardness			
Surfacing: higher-strength steels / cast steel grades	100 – 200 °C (212 – 392 °F)	None; if necessary tempering to required hardness			