



Unibraze 410T1

All Position

Classifications:

E410T1-1, E410T1-4 per AWS A5.22

Description:

Unibraze 410T1 is a gas-shielded, flux cored, stainless steel electrode that contains 12% chromium. The weld deposit is air hardening and is normally heat-treated after welding.

Characteristics:

Unibraze 410T1 has superb all position performance with a flat, well washed bead profile that is achieved with minimal weaving. This electrode produces very low spatter and slag peeling is excellent, thus reducing cleanup time.

Applications:

Unibraze 410T1's is commonly used to weld straight 410 stainless steel. This electrode provides good corrosion and oxidation resistance up to 1200°F.

Diameters: .045", 1/16"

Shielding Gases: 100% CO₂, 75-80% Ar/balance CO₂, 40-55 cfh

Welding Positions: All positions

Typical Mechanical Properties: (SR 1 Hr @ 1375°F)

	CO ₂	Ar/CO ₂ Mix
Ultimate Tensile Strength (psi)	96,700	91,900
Yield Strength (psi)	79,000	73,400
Percent Elongation	20	20

Typical Weld Deposit Chemistry:

CO ₂	C - 0.08	Mn - 0.70	Cr - 12.30	Si - 0.50
Ar/CO ₂ Mix	C - 0.08	Mn - 0.50	Cr - 11.50	Si - 0.57

Typical Welding Parameters: (CO₂)*

Diameter	Position	Optimum			Range	
		WFS (ipm)	Amperage	Voltage	Amps	Volts
.045"	Flat	450	250	28	130-300	21-32
.045"	Overhead	305	190	26	150-280	21-30
.045"	Vertical Up	305	190	25	130-260	21-29
1/16"	Flat	330	330	29	150-400	22-34
1/16"	Overhead	180	225	26	150-310	22-28
1/16"	Vertical Up	180	225	25	150-280	22-27

* Reduce by 1 volt when using Ar+20-25% CO₂.

Notice: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for use in the field. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.