

Stick Electrode for Stainless Steel

KS-410

Classification

AWS	A 5.4	E410-16
JIS	Z3221	ES410-16
EN	3581-A	E 13 R
GB	T 983	E410-16

Type of coating: Lime titania type

Applications and Features

- (1) Weld metal is 12%Cr, which is suitable for welding AISI 410 or AISI 420 types of stainless steel.
- (2) It maintains excellent oxidation and corrosion resistance at high temperature.
- (3) It obtains high hardenability after welding.
- (4) It is suitable for applications in petro-refining and chemical industries.

Welding Position

All Positions

Welding Instruction

- (1) Please refer to Appendix H for re-drying instructions.
- (2) For other instructions and information, please refer to Appendix F.
- (3) Apply 200~350°C preheat and 700~ 760°C PWHT in order to prevent cracking on weld bead and heat affected zone.

Typical Chemical Composition of Weld Metal (wt. %)

C	Si	Mn	P	S	Cr
0.080	0.35	0.65	0.018	0.012	13.01

Typical Mechanical Properties of Weld Metal (PWHT: 750°Cu 1Hr)

Tensile Strength N/mm ² (kgf/mm ²)	Yield Strength N/mm ² (kgf/mm ²)	Elongation %
510(52.0)	320(32.6)	28

Size and Suggested Operating Range (AC or DC+)

Diameter x Length (mm)	2.0x250	2.6x300	3.2x350	4.0x350	5.0x350	
Amp	F/H-Fillet	35~55	50~85	80~120	100~150	140~200
	V-up/OH	30~50	45~85	70~110	90~135	—