

## Stick Electrode for Stainless Steel

# KS-410NiMo

### Classification

AWS	A 5.4	E410NiMo-16
JIS	Z3221	ES410NiMo-16
EN	3581-A	E 13 4 R
GB	T 983	E410NiMo-16

Type of coating: Lime titania type

### Applications and Features

- (1) It provides outstanding crack resistance.
- (2) It is suitable for welding 13%Cr-Ni cast steel, such as SCS5 and CA6NM.

### 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.

### Typical Chemical Composition of Weld Metal (wt. %)

C	Si	Mn	P	S	Cr	Ni	Mo
0.040	0.31	0.58	0.020	0.003	12.29	4.55	0.60

### Typical Mechanical Properties of Weld Metal (PWHT: 600°C x 1Hr)

Tensile Strength	Yield Strength	Elongation
N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	%
850(86.7)	750(76.5)	22

### 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	—