GMAW Solid Wire for Stainless Steel

KMS-410

Shielding Gas: Ar+1~2%O_2(CO_2)

Classification

AWS	A5.9/A5.9M	ER410
JIS	Z3321	YS410
EN	14343-A	G 13
YB	T5092	H10Cr13

Applications and Features

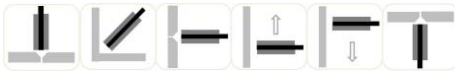
(1) Weld metal is martensitic structure with 13%Cr.

(2) To prevent the crack in beads and HAZ, please apply preheat temperature: 200~300°C, PWHT: 700~760 °C.

(3) Superior oxidation and corrosion resistance at 650 °C,.

(4) Suitable for welding petro-refining and chemical industry, such as AISI 410 or 420 stainless steel.

Welding Position



Welding Instruction

(1) Use Ar+1~2%O_2 for spray transfer and Ar+1~2%CO_2 for short-circuit transfer.

(2) For other instructions, please refer to Appendix B and F.

Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S	Cr
0.11	0.34	0.46	0.013	0.009	11.77

Typical Mechanical Properties of Weld Metal

Tensile Strength N/mm^2	Yield Strength N/mm^2	Elongation %
570	390	25

Size and Suggested Operating Range (DC+)

Diameter (mm)		0.8	0.9	1.0	1.2	1.4	1.6
Ar+1~2%CO_2	Current (A)	40~120	60~140	80~160	100~210	-	-
	Voltage (V)	15~20	15~21	16~22	17~22	-	-
Ar+1~2%O_2	Current (A)	160~210	170~260	180~280	200~300	210~320	220~330
	Voltage (V)	24~28	24~30	24~30	24~30	24~32	24~32