

Covered Electrodes

KST-410NiMo

For stainless steel (13%Cr-Ni-Mo, Hardfacing)

Classifications

EN ISO 3581-A:2012	: E 13 4 R 12	KS D 7014	: D410-16
EN ISO 3581-B:2012	: ES410NiMo-16	JIS Z 3221	: ES410NiMo-16
AWS A5.4-06	: E410NiMo-16		

Description

- Covering is lime titania type for welding of 13%Cr-Ni-Mo steel and surfacing of the part where require cavitation or corrosion resistance is required.
- Excellent oxidation corrosion and abrasion resistance of the deposited weld metal.
- Preheat at 100~250°C and postheat treat at 600~700°C because of high self-hardening property of the deposited weld metal.
- Redry the electrode at 250~350°C for 30~60 minutes prior to use.

Welding positions



Typical chemical composition of all-weld metal (%)

C	Si	Mn	P	S	Ni	Cr	Mo	Cu
0.02	0.49	0.35	0.030	0.012	4.71	11.70	0.62	0.30

Typical mechanical properties of all-weld metal

	Y.S (0.2%OS) (MPa)	T.S (MPa)	El. (%)	Remarks
AWS A5.4		min. 760	min. 15	
JIS Z 3221		min. 760	min. 10	
Example	820	930	17	PWHT

*PWHT : 610°Cx1Hr. & Air cooling

Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	300	350	350	350
Amp. (A)	F V · OH	60~90 45~60	80~110 70~90	110~150 90~130	150~180 -