KST-410

For stainless steel (13%Cr, Hardfacing)

Classifications

EN ISO 3581-A:2012	: E 13 R 12	KS D 7014	: E410-16
EN ISO 3581-B:2012	: ES410-16	JIS Z 3221	: ES410-16
AWS A5.4-06	: E410-16		

Description

- Covering is lime titania type for welding of 13%Cr 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℃ and postheat treat at 700~800℃ because of high self-hardening property of the deposited weld metal.
- Redry the electrode at 250~350℃ 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
0.08	0.70	0.76	0.030	0.004	0.15	12.10	0.10	0.08

Typical mechanical properties of all-weld metal

	Y.S (0.2%OS) (MPa)	T.S (MPa)	El. (%)	Remarks
AWS A5.4		min. 450	min. 20	
EN ISO 3581-A	min. 250	min. 450	min. 15	
Example	400	560	24	PWHT

*PWHT : 750℃x1Hr.

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.	F	60~90	80~110	110~150	150~180
(A)	V · OH	45~60	70~90	90~130	–

Approvals

CE