

Typical applications

K-410NiMoT is designed for MAG welding of soft-martensite stainless alloys of the 13%Cr-4%Ni-Mo types. (AISI 403, 405, 410, 420, JIS SCS3, SCS6, ASTM CA15M, CA6NM)

Characteristics on Usage

- ① Wire is a metal type of flux cored wire for flat and horizontal position welding.
- ② K-410NiMoT features very good ductility, CVN toughness and crack resistance.
- ③ The machinability of the weld metal depends largely upon the kind of base metal and degree of dilution.
- ④ The shielding gas should be used 80%Ar+20%CO₂ for welding.
- ⑤ Preheating and interpass temperatures in case of thick-walled sections 100~160°C and maximum heat input 15kJ/cm and Tempering at 580~620°C.
- ⑥ Refer to page 150 for more information on usage.

Typical chemical composition of all-weld-metal (%)

Shielding Gas	C	Si	Mn	Cr	Ni	Mo
Ar+20%CO ₂	0.04	0.23	0.36	12.2	4.1	0.7

Typical mechanical properties of all-weld-metal

Shielding Gas	T · S N/mm ² {kgf/mm ² }	El (%)	PWHT
Ar+20%CO ₂	870 {89}	25	600°C X 1hr.

Sizes available and recommended currents (DC wire⊕)

Dia. (mm)	Amp.	Electrode extensin (mm)
1.2	100~240	10~20
1.6	180~280	15~20

Welding positions



Approved by