

K-410T

AWS E410T0-1/4
JIS YF 410C
KS YF 410C

FOR STAINLESS STEEL

Typical applications

K-410T is designed for MAG welding of martensite stainless alloys of the 13%Cr types. It is used for surfacing of sealing faces of valves for gas, water, and steam piping system at service temperatures up to 450°

Characteristics on Usage

- ① Wire is a metal type of flux cored wire for flat and horizontal position welding.
- ② K-410T is suitable for the first layer of corrosion resistant weld claddings.
- ③ The shielding gas should be used 100%CO₂ and 80%Ar+20%CO₂ for welding.
- ④ For joint welding preheating to 200~300°C is recommended and tempering at 700~750°C to increase toughness.
- ⑤ Refer to page 150 for more information on usage.

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

Shielding Gas	C	Si	Mn	Cr
CO ₂	0.07	0.20	0.47	13.0
Ar+20%CO ₂	0.07	0.32	0.69	13.2

Typical mechanical properties of all-weld-metal

Shielding Gas	T · S N/mm ² {kgf/mm ² }	El (%)	PWHT
CO ₂	530 {54}	24	750°C X 1hr.
Ar+20%CO ₂	570 {58}	22	

Sizes available and recommended currents (DC wire[⊕])

Dia. (mm)	Amp.	Electrode extensin (mm)
1.2	100~240	10~20
1.6	180~270	15~25

Welding positions



Approved by

JIS