

FOR STAINLESS STEEL

AWS E410-16  
JIS D410-16  
KS D410-16

# KST-410

## Typical applications

Welding of 13%Cr steel and surfacing of the part where require cavitation or corrosion resistance is required.

## Coating

Lime titania type.

## Characteristics on Usage

- ① Excellent oxidation corrosion and abrasion resistance of the deposited weld metal.
- ② Preheat at 100~200°C and postheat treat at 700~800°C because of self-hardening property of the deposited weld metal.
- ③ Redry the electrode at 200~250°C for 60 minutes prior to use.

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

C	Si	Mn	Cr
0.08	0.70	0.76	12.1

## Typical mechanical properties of all-weld-metal

T · S N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	EI (%)	PWHT
560 {57}	24	730°C × 1hr. S · R

## 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
	V&OH	45~60	70~90	90~130	—

## Welding positions



Approved by