

K-410NiMoT

Martensitic Stainless welding wire (13%Cr-Ni, Hardfacing)

Classifications

| | | | |
|---------------------|-----------------|--------------|-----------------|
| EN ISO 17633-A:2008 | : T 13 4 R M 4 | AWS A5.22-15 | : E410NiMoT0-4 |
| EN ISO 17633-B:2008 | : TS410NiMo-FM0 | JIS Z 3323 | : TS410NiMo-FM0 |

Description

- 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)
- Wire is a metal type of flux cored wire for flat and horizontal position welding.
- K-410NiMoT features very good ductility, CVN toughness and crack resistance.
- The machinability of the weld metal depends largely upon the kind of base metal and degree of dilution.

Welding positions



Polarity & shielding gas

- Mix: Ar+20% CO₂ (15~25l/min)
- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

| Shielding gas | C | Si | Mn | Cr | Ni | Mo |
|---------------|------|------|------|-------|------|------|
| Mix | 0.04 | 0.23 | 0.36 | 12.20 | 4.10 | 0.70 |

Typical mechanical properties of all-weld metal

| | Y.S (MPa) | T.S (MPa) | El. (%) | PWHT |
|----------------|--------------|--------------|------------|-----------|
| AWS A5.22 | | min. 760 | min. 15 | |
| EN ISO 17633-B | min. 500 | min. 750 | min. 15 | |
| Example (Mix) | 745 | 900 | 18 | 620°Cx1Hr |

^① After machining, but before testing, the specimen was aged at a temperature 100°C for up to 48 hours then allowed to cool to room temperature.

Notes on usage and welding condition

- Refer to page 303 for more information on usage
- 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.

Package

| Dia. (mm) | 1.2 | 1.4 | 1.6 |
|---------------|-----------------|-----|-----|
| Spool (kg) | 5, 12.5, 15, 20 | | |
| Pailpack (kg) | 100 ~ 300 | | |