

K-410NiMoTC

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

Classifications

EN ISO 17633-A:2008	: T 13 4 P C 1	AWS A5.22-15	: E410NiMoT1-1
EN ISO 17633-B:2008	: TS410NiMo-FC1	JIS Z 3323	: TS410NiMo-FC1

Description

- K-410NiMoTC is designed for MAG welding of soft-martensite stainless alloys of the 13%Cr-4%Ni-Mo types (AISI 403, 405, 410, JIS SCS3, SCS6, SB410, ASTM CA15M, CA6NM)
- Wire is a titania type of flux cored wire for all-position welding with 100%CO₂ gas.
- It features self-detaching slag, spray-like transfer, low spatter generation, smooth bead surface and high X-ray safety.
- The machinability of the weld metal depends largely upon the kind of base material and the degree of welding dilution.

Welding positions



Polarity & shielding gas

- CO₂: 100% CO₂ (15~25ℓ/min)
- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	Cr	Ni	Mo
CO ₂	0.04	0.55	0.45	12.20	4.80	0.55

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 (CO ₂)	900	950	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		