

Classifications

EN ISO 17633-A:2008	: T 13 R C(M) 4	AWS A5.22-13	: E410T0-1/4
EN ISO 17633-B:2008	: TS410-FB0	JIS Z 3323	: TS410-FB0

Description

- K-410T is designed for MAG welding of martensite stainless alloys of the 13%Cr types and used for surfacing of sealing faces of valves for gas, water, and steam piping system at service temperatures up to 450°C.
- Wire is a metal type of flux cored wire for flat and horizontal position welding.
- K-410T is suitable for the first layer of corrosion resistant weld claddings.

Welding positions**Polarity & shielding gas**

- CO₂: 100% CO₂,
- Mix: Ar+20% CO₂ (15~25ℓ/min)
- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	P	S	Cr
CO ₂	0.07	0.28	0.35	0.012	0.005	12.85
Mix	0.07	0.34	0.45	0.011	0.005	13.00

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	PWHT
EN ISO 17633-B		min. 450	min. 15	
Example (CO ₂)	380	530	28	750°C×1Hr

☞ 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
- For joint welding, preheating to 200~300°C is recommended and tempering at 700~750°C to increase toughness.

Package

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