

K-410NiMoTC

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

Classifications

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

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

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

	Yield Strength	Tensile Strength	Elongation	PWHT
	(MPa)	(MPa)	(%)	
AWS A5.22		Min. 760	Min. 15	
EN ISO 17633-B	Min. 500	Min. 750	Min. 15	
Example (CO ₂)	900	950	18	620 °C

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

Notes on usage and welding condition

- Preheating and Interpass temperatures in case of thick-walled section 100-160°C and maximum heat input 15KJ/cm and tempering at 580-620°C.

Package

Diameter (mm)	1.2, 1.4, 1.6
Spool (kg)	5, 12.5, 15, 20
Coil (kg)	100 - 300

Operating data

Diameter	(mm)	1.2	1.4	1.6
Amperage (A)	F (PA/1G)	160-340	200-380	240-420
Voltage (V)		24-32	25-33	26-35