

KT-410

Classification

AWS A5.9/A5.9M

ER410

Applications and Features

- (1) Weld metal is martensitic structure with 13%Cr.
- (2) To prevent cracking in welds and HAZ, apply preheat temperature: 200~300°C, PWHT: 700~760°C.
- (3) Superior oxidation and corrosion resistance at 650°C.
- (4) It is suitable for welding petro-refining and chemical industry, such as AISI 410 or 420 stainless steel.

Typical Chemical Composition (wt%)

C	Si	Mn	P	S	Cr	Ni
0.11	0.42	0.44	0.013	0.011	12.35	0.16

Typical Mechanical Properties of Weld Metal (Shielding Gas : Ar)

Tensile Strength MPa	Yield Strength MPa	Elongation %
525	340	26

Sizes and Suggested Operating Range

Size mm	Current A	Gas Flow L/min	Shielding Gas
1.6	75- 100	25	Ar

Diam.	5 kg Tube
1.6mm	KT41016