

# KST-410

For stainless steel (13%Cr, Hardfacing)

## Classifications

EN ISO 3581-A:2012	: E 13 R 12
EN ISO 3581-B:2012	: ES410-16
AWS A5.4-06	: E410-16
KS D 7014	: E410-16
JIS Z 3221	: ES410-16

## Approvals

CE

## Description

- Covering is lime titania type for welding of 13%Cr steel and surfacing of the part where cavitation or corrosion resistance is required
- Excellent oxidation corrosion and abrasion resistance of the deposited weld metal
- Preheat at 100-250°C and postheat treat at 700-800°C because of high self-hardening property of the deposited weld metal
- Redry the electrode at 250 - 350 °C for 30 – 60 minutes prior to use

## Welding positions



## Typical chemical composition of all-weld metal (%)

C	Si	Mn	P	S	Ni	Cr	Mo	Cu
0.08	0.70	0.76	0.030	0.004	0.15	12.10	0.10	0.08

## Typical mechanical properties of all-weld metal

	Yield Strength (0.2%OS)	Tensile Strength	Elongation	Remarks
	(MPa)	(MPa)	(%)	
AWS A5.4		Min. 450	Min. 20	
EN ISO 3581-A	Min. 250	Min. 450	Min. 15	
Example	400	560	24	PWHT

\*PWHT: 750°C x 1Hr

## Sizes available and recommended currents (AC or DC +)

Diameter	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	300	350	350	350
Amperage	F	60-90	80-110	110-150	150-180
	V . OH	45-60	70-90	90-130	-