NC-410

For 13%Cr stainless steel

AWS A5.4 E410-16
KS D 7014 E410-16
JIS Z3221 ES410-16

Applications

Welding of SUS 403, 410 stainless steels and SUS 420J1, J2 and welding of hard-surfacing for corrosion resistance.

Characteristics

The weld metal is of martensite structure containing ferrite with self-hardening property. Cavitation-abrasion, corrosion and oxidation resistibilities of weld metal are good.

Notes on usage

(1) Keep the arc as short as possible.
(2) Weaving width should be within two and a half times electrode diameter.
(3) When the electrodes have absorbed moisture, dry them at 300~350℃ for 30~60 minutes before use.
(4)

Preheat, interpass temp.	PWHT
200~400℃	700~760℃

Typical chemical composition of weld metal (%)

C	Mn	Si	P	S	Ni	Cr
0.08	0.43	0.24	0.024	0.003	0.19	12.80

Typical mechanical properties of weld metal

TS N/mm²(kgf/mm²)	EL %	PWHT
550(56)	29	730~760℃×1hr. Air cooling after slowly cooled down to 315℃

Size & recommended current range (AC or DC +)

Dia. (mm)		2.6	3.2	4.0	5.0
L (mm)		300	350	350	350
Amp.	F	50-85	70-115	95-145	135-180
	V&OH	45-80	65-110	85-135	-

• Tip Color : Black