



ENAR WELD BRAZE PVT. LTD

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KISWEL K-410NiMoT

Classifications:

EN ISO 17633-A:2008 : T 13 4 P M 4
EN ISO 17633-B:2008 : TS410NiMo-FM0

AWS A5.22-07 : E410NiMoT0-4
JIS Z 3323 : TS410NiMo-FM0

Typical Chemistry Composition of Weld Deposit:

Shielding Gas	C	Si	Mn	Cr	Ni	Mo
Ar + 20%CO ₂	<0.06	<1.00	<1.00	11.00 – 12.50	4.00 – 5.00	0.40 – 0.70

Description:

- K-410NiMoT is designed for MAG welding of soft-martensite stainless alloys of the 13%Cr-4%Ni-Mo types. (AISI 403, 405, 410, 420, JIS SCS3, SCS6, ASTM CA15M, CA6NM)
- Wire is a metal type of flux cored wire for flat and horizontal position welding.
- K-410NiMoT features very good ductility, CVN toughness and crack resistance.
- The machinability of the weld metal depends largely upon the kind of base metal and degree of dilution.

Typical Mechanical Properties:

Yield Strength
(Mpa)
min. 500

Tensile Strength
(Mpa)
min. 700

Elongation
(%)
min. 15