

COVERED ELECTRODES FOR STAINLESS STEEL

DESCRIPTION & APPLICATIONS :

- SS-410NM is a titanium oxide low hydrogen electrode, the weld metal contains 12%Cr-5%Ni-0.5%Mo the martensitic structure.
- Advantage of arc stability, less spatters, slag removal, anti-cracking, and toughness.
- It is suitable for ASTM CA6NM series the martensitic stainless steel in all welding positions.

NOTE ON USAGE :

- Re bake the electrodes at 250 ~ 300°C for 1 hour and keep it at 100~150°C prior to use.
- With lower current is to properly keep the dilution of the parent metal for welding crack.
- Preheat at 100 ~ 150°C before welding, and the PWHT at 600 ~ 620°C afterwards.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S	Ni	Cr	Mo
0.03	0.25	0.32	0.028	0.009	4.58	11.46	0.53

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

YIELD POINT N/mm ² (Kgf/mm ²)	TENSILE STRENGTH N/mm ² (Kgf/mm ²)	ELONGATION RATE %	HEAT TREATMENT
940(95.9)	988(100.8)	19	620°Cx1hr

SIZE AND RECOMMENDED CURRENT RANGE : AC or DC(+)

Diameter (mm)		2.6	3.2	4.0	5.0
Length (mm)		300	350	350	350
Current (Amp)	F	60-85	80-120	100-150	140-170
	V & OH	60-80	65-105	95-140	-