

COVERED ELECTRODES FOR STAINLESS STEEL

DESCRIPTION & APPLICATIONS :

- SS-410 is a titanium oxide low hydrogen electrode, the weld metal contains 13%Cr the martensitic structure.
- The hardness, weldbead, or HAZ (Heat Affected Zone) tend to easily crack, the advantage of oxidation and corrosion resistances at high temp.
- It is suitable for SUS 403, 410, 410S, and SUS 420J1, 420J2 steels.

NOTE ON USAGE :

- Rebake 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 200 ~ 400°C before welding, and the PWHT at 700 ~ 760°C afterwards.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S	Ni	Cr
0.02	0.30	0.62	0.028	0.008	0.15	13.40

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

TENSILE STRENGTH N/mm ² (Kg/mm ²)	ELONGATION RATE %	HEAT TREATMENT
540(55.1)	22	730°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	-