

# LKE-410-16



LINKWELD ALLOYS INC.

AWS	A5.4 E410-16
EN	EN1600 E 13 R 1 2
JIS	Z3221 D410-16

## Characteristics:

LKE-410 is used to give a ferritic weld metal of 13%Cr type for welding and building up of ferritic-martensitic steels. With good oxidization and corrosion resistance.

## Applications:

It is suitable for welding of the AISI 410 and AISI 420. Typical applications include constructions exposed to aggressive sulphuric gases in refineries, oil and gas industries and chemical plants.

## Notes on Usage:

1. Dry the electrodes at 250-300°C for 60 minutes and keep at 100-150°C before use.
2. Use lower currents and keep the arc as short as possible.
3. Preheat at 200-250°C, interpass temperature 180-250°C and post-weld heat treatment at 700-800°C

## Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S	Cr	Ni
0.03	0.35	0.60	0.025	0.010	12.50	0.40

## Typical mechanical properties of weld metal

TS N/mm <sup>2</sup>	EL %	PWHT
540	24	750°C x1hr

## Welding position:



## Sizes and recommended current range (AC or DC <+> )

Diameter (mm)		2.6	3.2	4.0	4.8
Length (mm)		300	350	350	350
Amps	F	60-90	80-130	130-170	180-210
	V&OH	50-70	70-110	100-130	-
Weight per pack(kg)		4/5	5	5	5
Weight per carton (kg)		20	20	20	20