

CSF-410

For 13%Cr Stainless steel

AWS A5.22 E410T0-1/-4
KS D 3612 YF410C
JIS Z3323 TS410-FB(0)

Applications

CSF-410 is suitable for welding of base metals of similar composition.

Characteristics

- (1) CSF-410 is flux cored wire and designed for Fillet & H-F welding with CO₂ gas Shielding.
- (2) It provides the excellent usability with stable arc, less spattering, good bead appearance, better slag removal, and less quantity of welding fume comparable to solid wire.
- (3) Is containing Ferrite of a reasonable quantity and crack-resistance, intergranular corrosion resistance, mechanical properties of weld metal is superior.
- (4) Shield gas is 100%CO₂ or Ar+CO₂ gas.

Notes on usage

- (1) The optimum flow of CO₂ for Shielding is 20~25ℓ/min.
- (2) Protect the weld with a screen to prevent blowholes caused by wind where the wind velocity is 2m/sec and more.
- (3) Keep the distance between tip & base metal at 15~25mm.

Typical chemical composition of weld metal (%)

(Shielding Gas : 100%CO₂)

C	Mn	Si	P	S	Cr	Ni
0.05	0.76	0.53	0.027	0.007	12.8	0.20

Typical mechanical properties of weld metal

(Shielding Gas : 100%CO₂)

YP N/mm ² (MPa)	TS N/mm ² (MPa)	EL %
350	560	28

Size & recommended current range (DC+)

Dia. mm (in)	Current(A)	Voltage(V)	Welding Speed(cm / min)
1.2(0.045)	150-300	24-33	20-60
1.6(0.062)	200-400	24-33	20-60