

AK E410-16

Description: AK-E410-16 is a Cr13 stainless steel electrode with rutile coating. It can be used for both AC and DC, and can perform all-position welding. It has good welding process performance, stable arc, small spatter, easy slag removal, and beautiful welding seam. The coating of the electrode is not easy to redden, has good strength and good porosity resistance.

Application: It is suitable for welding stainless steel structures such as 06Cr13 and 12Cr13, and can also be used for corrosion-resistant and wear-resistant surface surfacing.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Mo	Cr	Cu
Requirement	0.12	0.90	1.0	0.03	0.04	0.7	0.75	11.0-14.0	0.75
Actual Result	0.08	0.56	0.37	0.012	0.027	0.18	0.11	12.01	0.03

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥450		≥ 15	
Actual Result	610		23	

Recommended welding parameters:

Diameter/mm		2.5	3.2	4.0
Welding current/A	F/H	60-80	80-120	100-150
	V/ OH	40-70	60-100	80-130