

KT-410

Classification

AWS	A 5.1/A5.1M	E6010/E4310
JIS	Z3211	E4310
EN	2560-A	E35 0 C 2 1
GB	T5117	E4310

Type of coating : High cellulose type

Applications and Features

- (1) Designed for welding root pass of pipeline with DC polarity.
- (2) Strong arc force, deep penetration, fast-freeze slag and good weldability.
- (3) Typical applications are high pressure pipes, oil tanks, boilers and outdoor welding.

Welding position



Welding Instruction

- (1) Do not over dry the electrode or operate under high current, which can cause early decomposition of the coating and affect the welding performance.
- (2) Please refer to Appendix A

Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S
0.09	0.17	0.29	0.020	0.005

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	°C	J
471	393	26	0	85
			-20	50

Size and Suggested Operating Range (DC±)

Diameter (mm)		2.4	3.2	4.0
Current (A)	DC+	50~70	75~125	100~165
	DC-	50~70	75~125	100~165