7 Buccleuch Avenue,
Craighall Park,
Johannesburg, 2196,
South Africa

NOCKERS
ENGINEERING PRODUCTS

+ 27 11 447 8562
sales@nockers.co.za
www.nockers.co.za

FLUX CORE WIRES FOR STAINLESS STEEL

Brand Name	Size (mm)	Equivalent Specification		Welding Position	Shielding Gas	Type of Current	Typical Chemical Composition of All-Weld Metal (%)								Typical Mechanical Properties of All-Weld Metal			Characteristics and Applications	Approvals
							C	Si	Mn	P	S	Cr	Ni	Mo	T.S (MPa)	El. (%)	I.V (J)		
K-308T	1.2~1.6	AWS A5.22 JIS Z3323 KS D3612 EN ISO 17633-B	E308T0-1/4 TS308-FB0 YF308C TS308-FB0	F, H-Fil	CO_2 / Ar+20%CO_2	DC(+)	0.04	0.60	1.15	0.022	0.008	20.4	10.6	-	580	39	60 (-40℃)	K-308T is designed for MAG welding of 18%Cr-8%Ni stainless steels and also formulated for operation primarily in the flat position and for welding horizontal fillet welds. It is a titania type of flux cored wire for AISI 304 and 304H steel type and has low spatter generation, easy slag removal and good weld soundness.	ABS, BV, DNV, NK, CE, JIS
K-308LT	1.2~1.6	AWS A5.22 JIS Z3323 KS D3612 EN ISO 17633-A EN ISO 17633-A EN ISO 17633-B	E308LT1-1/4 TS308L-FB1 YF308LC T19 9L PC1 T19 9L PM1 TS308L-FB1	F, V, OH H, VD	CO_2 / Ar+20%CO_2	DC(+)	0.03	0.60	1.20	0.023	0.009	20.3	10.5	-	570	39	65 (-40℃)	K-308LT is designed for MAG welding of low carbon 18%Cr-8%Ni stainless steel and used to joint austenitic stainless steel (AISI 304, 304L, 304LN, ASTM A157 Gr. C9; A320 Gr. B8C or D) The weld metal contains optimum ferrite contents in their austenitic structures, Therefore their weldability is excellent with lower crack susceptibility.	ABS, BV, DNV, NK, LR, KR, CCS, CWB, CE, TUV, JIS
K-308LB	1.2~1.6	AWS A5.22 JIS Z3323 KS D3612 EN ISO 17633-A EN ISO 17633-A EN ISO 17633-B	E308LT1-1/4 TS308L-BiF-FB1 YF308LC T19 9L PC1 T19 9L PM1 TS308L-FB1	F, V, OH H, VD	CO_2 / Ar+20%CO_2	DC(+)	0.03	0.48	1.15	0.022	0.010	19.3	10.0	Bi : <10ppm	560	38	56 (-40℃)	K-308LB is designed for MAG welding of high carbon 18%Cr-8%Ni stainless steels with high temperature heat treatment such as solution treatment. It is a titania type of flux cored wire without Bi component for all-position welding.	CE
K-308LS	1.2~1.6	AWS A5.22 JIS Z3323 KS D3612 EN ISO 17633-B	E308LT1-1 TS308L-FC1 YF308LC TS308L-FC1	F, V, OH H, VD	CO_2	DC(+)	0.03	0.42	2.00	0.020	0.006	19.0	10.5	-	560	43	40 (-196℃)	K-308LS is designed for MAG welding of low carbon 18%Cr-8%Ni stainless steels and recommended to be used for low temperature service (STS 304, 304L, 304LN, ASTM A157 Gr C9; A320 Gr. B8C or D) It is a titania type of flux cored wire for all-position welding and formulated to focus on mechanical properties more than welding arc stability and provides good corrosion resistance, heat resistance properties.	CE, JIS
K-308LF	1.2~1.6	AWS A5.22 JIS Z3323 KS D3612 EN ISO 17633-A EN ISO 17633-B EN ISO 17633-A	E308LT0-1/4 TS308L-FB0 YF308LC T19 9L RC4 T19 9LRM4 TS308L-FB0	F, H-Fil	CO_2 / Ar+20%CO_2	DC(+)	0.03	0.52	1.45	0.024	0.008	20.1	9.6	-	560	40	60 (-40℃)	K-308LF is designed for MAG welding of low carbon 18%Cr-8%Ni stainless steel and used to joint 301, 302, 304 and 308 stainless steel. It is formulated for operation primarily in the flat position and for welding horizontal fillet welds.	CE, JIS
K-NGS308L	0.8~1.2	AWS A5.22	E308LT0-3	F, H-Fil	None												85 (-20℃)	K-NGS308L is designed for self-shielded welding of low carbon 18%Cr-8%Ni stainless steel and used to join STS 304, 304L, 308, 201, 202, 203 etc. It is a lime- titania type of flux cored wire for flat and horizontal welding position without shielding gas.	-

Brand Name	Size (mm)	Equivalent Specification		Welding Position	Shielding Gas	Type of Current	Typical Chemical Composition of All-Weld Metal (%)								Typical Mechanical Properties of All-Weld Metal			Characteristics and Applications	Approvals
							C	Si	Mn	P	S	Cr	Ni	Mo	T.S (MPa)	El. (%)	I.V (J)		
K-NGS308L	0.8~1.2	AWS A5.22	E308LT0-3	F, H-Fil	None												85 (-20℃)	K-NGS308L is designed for self-shielded welding of low carbon 18%Cr-8%Ni stainless steel and used to join STS 304, 304L, 308, 201, 202, 203 etc. It is a lime- titania type of flux cored wire for flat and horizontal welding position without shielding gas.	-
K-308HT	1.2~1.6	AWS A5.22 JIS Z3323 EN ISO 17633-B	E308HT1-1/4 TS308H-FB1 TS308H-FB1	F, V, OH H, VD	CO_2 / Ar+20%CO_2	DC(+)	0.06	0.65	1.00	0.022	0.008	19.5	10.5	-	600	39	45 (-40℃)	K-308HT is designed for MAG welding of high carbon 18%Cr-8%Ni stainless steels (STS 304H, 307H) and recommended to be use for high temperature service (about 600℃) It is a titania type of flux cored wire for all-position welding and has excellent feedability and increased creep resistance at elevated temperature.	CE, JIS
K-308HB	1.2~1.6	AWS A5.22 JIS Z3323 EN ISO 17633-B	E308HT1-1/4 TS308H-BiF-FB1 TS308H-FB1	F, V, OH H, VD	CO_2 / Ar+20%CO_2	DC(+)	0.06	0.48	1.65	0.022	0.010	19.7	9.8	Bi : <10ppm	600	38	60 (-40℃)	K-308HB is designed for MAG welding of high carbon 18%Cr-8%Ni stainless steels (STS 304H, 307H) and recommended to be use for high temperature service (about 600℃) It is a titania type of flux cored wire without Bi component for all-position welding and has excellent feedability and increased creep resistance at elevated temperature.	-
K-309T	1.2~1.6	AWS A5.22 JIS Z3323 KS D3612 EN ISO 17633-B	E309T0-1/4 TS309-FB0 YF309C TS309-FB0	F, H-Fil	CO_2 / Ar+20%CO_2	DC(+)	0.04	0.58	1.45	0.023	0.008	23.5	13.0	-	590	35	40 (-40℃)	K-309T is formulated for MAG welding of 22%Cr-12%Ni stainless steels and typical applications is for welding of dissimilar steels, such as 304 to mild steel or low alloy steels. It is a titania type of flux cored wire for cladding and dissimilar joint welds. Weld metals contain comparatively much more ferrite in their austenitic, therefore they provide better weldability together with superior heat resistance, and corrosion resistance.	ABS, BV, DNV, NK, LR, KR, CE, JIS
K-309LT	1.2~1.6	AWS A5.22 JIS Z3323 KS D3612 EN ISO 17633-A EN ISO 17633-A EN ISO 17633-B	E309LT1-1/4 TS309L-FB1 YF309LC T23 12L PC1 T23 12L PM1 TS309L-FB1	F, V, OH H, VD	CO_2 / Ar+20%CO_2	DC(+)	0.03	0.60	1.15	0.023	0.007	23.7	13.2	-	560	37	45 (-35℃)	Dissimilar joint welds; of and between high-strength, mild steels and low allowed QT-steels, stainless, ferritic Cr- and austenitic Cr-Ni-steels, manganese steels Cladding; for the first layer of corrosion resistant weld claddings on ferritic-perlitic steels in boiler and pressure vessel parts up to fine-grained steel S500N. Weld metal contains comparatively much more ferrite in their austenitic structure, therefore they provide better weldability together with superior heat resistance, and corrosion resistance.	ABS, BV, DNV, NK, LR, KR, CCS, CWB, CE, TUV, JIS, RINA
K-309LF	1.2~1.6	AWS A5.22 JIS Z3323 KS D3612 EN ISO 17633-A EN ISO 17633-A EN ISO 17633-B	E309LT0-1/4 TS309L-FB0 YF309LC T23 12L RC4 T23 12L RM4 TS309L-FB0	F, H-Fil	CO_2 / Ar+20%CO_2	DC(+)	0.03	0.60	1.42	0.022	0.009	23.3	13.2	-	560	37	43 (-30℃)	Dissimilar joint welds; of and between high-strength, mild steels and low allowed QT-steels, stainless, ferritic Cr- and austenitic Cr-Ni-steels, manganese steels Cladding; for the first layer of corrosion resistant weld claddings on ferritic-perlitic steels in boiler and pressure vessel parts up to fine-grained steel S500N. Wire is a titania type of flux cored wire for flat and horizontal position welding and it provides better weldability together with excellent corrosion resistance.	CE, JIS
K-309LMT	1.2~1.6	AWS A5.22 JIS Z3323 KS D3612 EN ISO 17633-B	EC309L TS309L-MA0 YF309LG TS309L-MA0	F, H-Fil	Ar+2%O_2	DC(+)	0.03	0.50	1.65	0.022	0.006	23.9	12.6	-	560	40	50 (-30℃)	K-309LMT is designed for MAG welding of low carbon 22%Cr-12%Ni stainless steels and It is suitable for automotive exhaust fabricators such as front pipe, bellows, flange (AISI 409, 436 and dissimilar joint welds) Slag quantity is almost the same as solid wire and deposition rate is up to 20% higher than solid wire's one. K-309LMT provides low spatter, excellent bead appearance and porosity resistance.	CE, JIS

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							C	Si	Mn	P	S	Cr	Ni	Mo	T.S (MPa)	El. (%)	I.V (J)		
K-309LMTS	1.2~1.6	JIS Z3323 EN 17633	TS309L-MA0 TS309L-MA0	F, H-Fil	Ar+2%O_2	DC(+)	0.03	0.47	1.60	0.020	0.007	23.4	13.4	-	560	40	60 (-30℃)	K-309LMT is designed for MAG welding of low carbon 22%Cr-12%Ni stainless steels and it is suitable for automotive exhaust fabricators such as front pipe, bellows, flange (AISI 409, 436 and dissimilar joint welds) Slag quantity is almost the same as solid wire and deposition rate is up to 20% higher than solid wire's one. K-309LMT provides low spatter, excellent bead appearance and porosity resistance.	-
K-309MoLT	1.2~1.6	AWS A5.22 JIS Z3323 KS D3612 EN ISO 17633-A EN ISO 17633-B	E309LMoT1-1 TS309LMo-FC1 YF309MoLC T23 12 2L PC1 TS309LMo-FC1	F, V, OH H, VD	CO_2	DC(+)	0.03	0.60	1.00	0.020	0.008	23.8	14.6	2.5	700	30	35 (-30℃)	Dissimilar joint welds; of and between high-strength, mild steels and low-alloyed QT-steels, stainless, ferritic Cr- and austenitic Cr-Ni-steels, manganese steels. Cladding; for the first layer of corrosion resistant weld claddings on ferritic-perlitic steels in boiler and pressure vessel parts up to fine-grained steel S500N. Wire is a titania type of flux cored wire for all- position welding and for Mo-alloyed claddings the product is necessary for the 1st layer.	ABS, GL, KR, CE, JIS
K-310T	1.2~1.6	AWS A5.22 JIS Z3323 EN ISO 17633-A EN ISO 17633-B	E310T0-1 TS310-FC0 T25 20 PC4 TS310-FC0	F, H-Fil	CO_2	DC(+)	0.18	0.50	2.20	0.018	0.005	25.5	20.4	-	630	42	60 (-40℃)	K-310T is designed for MAG welding of 25% Cr-20%Ni stainless steels and the deposited weld-metal has perfect austenitic microstructure. It is formulated for operation primarily in the flat position and for welding horizontal fillet welds. It also features good mechanical properties and heat resistance of the deposited weld-metal.	-
K-312T	1.2~1.6	AWS A5.22 JIS Z3323 EN ISO 17633-A EN ISO 17633-B	E312T1-1 TS312-FC1 T29 9 PC1 TS312-FC1	F, V, OH H, VD	CO_2	DC(+)	0.06	0.55	1.25	0.022	0.007	30.3	10.1	-	760	25	-	K-312T is formulated for MAG welding of 30%Cr-9%Ni stainless steels and It is used for joining dissimilar steels, steels with reduced weldability and buffer layers prior to hard facing (rolls, forging dies, hotwork tools, dies for plastics and so on) It has resistance to stress corrosion and highly insensitive to dilution and good scaling resistance up to 1150℃.	CE, JIS
K-316T	1.2~1.6	AWS A5.22 JIS Z3323 KS D3612 EN ISO 17633-B	E316T0-1/4 TS316-FB0 YF316C TS316-FB0	F, H-Fil	CO_2 / Ar+20%CO_2	DC(+)	0.04	0.58	1.15	0.022	0.009	19.0	12.5	2.5	550	40	50 (-60℃)	K-316T is formulated for MAG welding of 18%Cr-12%Ni-2%Mo stainless steels where increased resistance to pitting corrosion is required (AISI 316, 316L). It is a titania type of flux cored wire for flat and horizontal position welding. Wire has low spatter, easy slag removal and good weld soundness.	ABS, KR, CE, JIS
K-316LT	1.2~1.6	AWS A5.22 JIS Z3323 KS D3612 EN ISO 17633-A EN ISO 17633-A EN ISO 17633-B	E316LT1-1/4 TS316L-FB1 YF316LC T19 12 3L PC1 T19 12 3L PM1 TS316L-FB1	F, V, OH H, VD	CO_2 / Ar+20%CO_2	DC(+)	0.03	0.60	1.15	0.023	0.010	19.5	12.7	2.5	560	38	50 (-60℃)	K-316LT is designed for MAG welding of low carbon 18%Cr-12%Ni-2%Mo stainless steels and this wire has low carbon content which gives good resistance to most types of corrosion of the weld metal (AISI 316L) Wire is a titania type of flux cored wire for all- position welding and the weld metal contains optimum ferrite contents in their austenitic structures, therefore their weldability is excellent with lower crack susceptibility.	ABS, BV, DNV, NK, LR, GL, CCS, CWB, TUV, CE, JIS
K-316LB	1.2~1.6	AWS A5.22 JIS Z3323 KS D3612 EN ISO 17633-A EN ISO 17633-A EN ISO 17633-B	E316LT1-1/4 TS316L-BiF-FB1 YF316LC T19 12 3L PC1 T19 12 3L PM1 TS316L-FB1	F, V, OH H, VD	CO_2 / Ar+20%CO_2	DC(+)	0.03	0.45	1.25	0.022	0.007	19.5	10.0	2.5 Bi :<10ppm	560	42	50 (-105℃)	K-308HB is designed for MAG welding of high carbon 18%Cr-8%Ni stainless steels (STS 316L, 316Ti) and recommended to be use for high temperature service (about 600℃). It is a titania type of flux cored wire without Bi component for all-position welding and has excellent feed ability and increased creep resistance at elevated temperature.	-

Brand Name	Size (mm)	Equivalent Specification		Welding Position	Shielding Gas	Type of Current	Typical Chemical Composition of All-Weld Metal (%)								Typical Mechanical Properties of All-Weld Metal			Characteristics and Applications	Approvals
							C	Si	Mn	P	S	Cr	Ni	Mo	T.S (MPa)	El. (%)	I.V (J)		
K-316LS	1.2~1.6	AWS A5.22 JIS Z3323 KS D3612 EN ISO 17633-B	E316LT1-1 TS316L-FC1 YF316LC TS316L-FC1	F, V, OH H, VD	CO_2	DC(+)	0.03	0.50	1.60	0.020	0.007	17.5	12.5	2.5	550	40	35 (-196℃)	K-316LS is designed for MAG welding of low carbon 18%Cr-8%Ni-2%Mo stainless steels and recommended to be use for low temperature service (AISI 316L, 316Ti, 316Cb) It is a titania type of flux cored wire for all-position welding and formulated to focus on mechanical properties more than welding arc stability.	CE, JIS
K-316LF	1.2~1.6	AWS A5.22 JIS Z3323 KS D3612 EN ISO 17633-A EN ISO 17633-A EN ISO 17633-B	E316LT0-1/4 TS316L-FB0 YF316LC T19 12 3L RC4 T19 12 3L RM4 TS316L-FB0	F, H-Fil	CO_2 / Ar+20%CO_2	DC(+)	0.03	0.58	1.38	0.02	0.01	19.5	12.5	2.5	570	37	52 (-60℃)	K-316LF is designed for MAG welding of low carbon 18%Cr-12%Ni-2%Mo stainless steel and this wire has low carbon content which gives good resistance to most types of corrosion of the weld metal (AISI 316L, 316Ti, 316Cb) Wire is a titania type of flux cored wire for flat and horizontal position welding.	CE, JIS
K-317LT	1.2~1.6	AWS A5.22 JIS Z3323 KS D3612 EN ISO 17633-B	E317LT1-1 TS317L-FC1 YF317LC TS317L-FC1	F, V, OH H, VD	CO_2	DC(+)	0.03	0.56	1.00	0.022	0.008	19.6	13.3	3.9	650	32	44 (-40℃)	K-317LT is designed for MAG welding of low carbon 19%Cr-13%Ni-3%Mo stainless steels and the principal area of application is process and chemical plant, shipbuilding as well as nuclear plant industries (AISI 316L, 316LN, 317L, 317LN, UNS S31726) It contains higher levels of Mo for increased corrosion-resistance when compared to the K-316LT.	ABS, CE, JIS
K-347T	1.2~1.6	AWS A5.22 JIS Z3323 KS D3612 EN ISO 17633-B	E347T1-1 TS347-FC1 YF347C TS347-FC1	F, V, OH H, VD	CO_2	DC(+)	0.04	0.68	1.15	0.022	0.009	19.7	10.1	Nb:0.6	650	33	50 (-60℃)	K-347T is formulated for MAG welding of 19%Cr-9%Ni-Nb stainless steels (AISI 347, 321, ASTM A296; A157 Gr. C9; A320 Gr. B8C or D). Wire is a titania type of flux cored wire for all-position welding, and it has low spatter generation, easy slag removal and good weld soundness. NB component improves the resistance to intergranular corrosion of the weld metal.	CE, JIS
K-329T	1.2~1.6	AWS A5.22 JIS Z3323 EN ISO 17633-A EN ISO 17633-A EN ISO 17633-B	E2209T1-1/4 TS2209-FB1 T22 9 3NL PC1 T22 9 3NL PM1 TS2209-FB1	F, V, OH H, VD	CO_2	DC(+)	0.03	0.52	0.80	0.022	0.008	23.2	9.6	3.3	820	27	42 (-40℃)	K-329T is formulated for MAG welding of 23%Cr-9%Ni-3%Mo duplex stainless steel and this principal area of application is chemical plant and shipbuilding as well as nuclear plant industries (ASTM A185 Gr.51, UNS S31803, DIN 1.4462, JIS 329J1) Wire is a titania type of flux cored wire for all-position welding and it has a stable welding arc producing a weld with easy slag removal and minimal spatter.	ABS, DNV, CE, JIS
K-329TE	1.2~1.6	-		F, V, OH H, VD	CO_2	DC(+)	0.03	0.45	0.82	0.023	0.010	22.6	9.7	1.7	770	30	52 (-60℃)	K-329TE is formulated for MAG welding of 22%Cr-9%Ni-3%MnMo Lean duplex stainless steels and 'Lean duplex' steel have excellent strength and medium corrosion resistance. It is mainly intended for application such as civil engineering, storage tanks, containers etc. It provides a ferritic-austenitic weldment that combines many of the good properties of both ferritic and austenitic stainless steels.	-
K-325T	1.2~1.6	AWS A5.22-07 JIS Z3323	E2553T0-G TS329 J4L FC0	F, V, OH H, VD	CO_2	DC(+)	0.03	0.60	1.00	0.023	0.009	25.5	9.5	3.7	850	33	27 (-40℃)	K-325T is formulated for MAG welding of 25%Cr-9%Ni-3%MoCu duplex stainless steels and the typical application is chemical plant and shipbuilding as well as nuclear plant industries (UNS S32520, UNS S32550, S32750, S32900, JIS 329J4L) Wire is a titania type of flux cored wire for flat and horizontal position welding, and provides low spatter and fume generation and high efficiency in flat position.	CE, JIS

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							C	Si	Mn	P	S	Cr	Ni	Mo	T.S (MPa)	El. (%)	I.V (J)		
K-409TiT	1.2~1.6	AWS A5.9 EN ISO 17633-B	EC409 TS409-MA0	F, H-Fil	Ar+2%O_2	DC(+)	0.02	0.44	0.62	0.011	0.005	11.5	Ti:1.0	-	530	24	-	K-409TiT is developed to meet the needs of the automotive exhaust fabricators that desired a metal cored wire. It excels in the pulsed GMAW mode and additional applications include heat exchanger and recuperators, power plant reheater tubes etc. Wire is a metal type of flux cored wire for high-speed welding on the plates as possible.	ABS, CE
K-409TiC	1.2~1.6	AWS A5.9 EN ISO 17633-B	EC409 TS409-MA0	F, H-Fil	Ar+2%O_2	DC(+)	0.02	0.50	0.45	0.011	0.006	12.1	Ti:0.8	-	520	25	-	K-409TiC is developed to meet the needs of the automotive exhaust fabricators that desired a metal cored wire. It excels in the pulsed GMAW mode and additional applications include heat exchangers and recuperators, power plant reheater tubes etc. It would produce a moderately soft arc and high welding speed.	-
K-430T	1.2~1.6	AWS A5.22-95	E430T0-G	F, H-Fil	Ar+2%O_2	DC(+)	0.02	0.61	0.49	0.010	0.007	16.8	Ti:1.0	-	535	25	PWHT : 780×2hr. S.R.	K-430T is designed for MAG welding of ferrite stainless alloys of the 17%Cr-Ti types and suitable for automotive exhaust fabricators such as front pipe, bellows, flange, etc. (AISI 409, 430Ti, ASTM A176I) Wire is a metal type of flux cored wire for high-speed welding on the plate as possible and It would produce a moderately soft arc and high low spatter generation.	ABS, CE
K-430LNb	1.2~1.6	JIS Z3323 EN ISO 17633-B	TS430Nb-MA0 TS430Nb-MA0	F, H-Fil	Ar+2%O_2	DC(+)	0.02	0.26	0.27	0.009	0.005	17.8	Nb:0.6	-	530	22	PWHT : 780×2hr. S.R.	K-430LNb is designed for MAG welding of stainless steels of the 17%Cr-Nb steels and is suitable for automotive exhaust fabrications such as front pipe, bellows, flange etc. (AISI 430, 430Ti, 431) It is a metal type of flux cored wire for high-speed welding on the plate as possible. Would produce a moderately soft arc, low spatter generation and slag quantity is almost the same as solid wire and deposition rate is up to 20% higher than solid wire's one.	JIS
K-436T	1.2~1.6	-		F, H-Fil	Ar+2%O_2	DC(+)	0.03	0.35	0.63	0.010	0.006	17.5	Ti:0.5	1.1	490	23	PWHT : 780×2hr. S.R.	K-436T is designed for MAG welding of stainless steels of the 17%Cr-1%Mo-Ti types and suitable for automotive exhaust fabricators such as front pipe, bellows, flange, etc. (JIS 436L/436J1L) It would produce a moderately soft arc and high low spatter generation, and the Mo component in weld metal improves good crack resistance and heat resistance.	-
K-439T	1.2~1.6	-		F, H-Fil	Ar+2%O_2	DC(+)	0.03	0.33	0.64	0.010	0.008	16.5	Ti:0.9	-	435	24	PWHT : 780×2hr. S.R.	K-439T is designed for MAG welding of stainless steels of the 18%Cr-Ti types and suitable for automotive exhaust fabrications such as front pipe, bellows, flange etc. (AISI 430, 430Ti, 431) Wire is a metal type of flux cored wire for high-speed welding on the plate as possible and slag quantity is almost the same as solid wire and deposition rate is up to 20% higher than solid wire's one.	-
K-410T	1.2~1.6	AWS A5.22 JIS Z3323 KS D3612 EN ISO 17633-A EN ISO 17633-A EN ISO 17633-B	E410T0-1/4 TS410-FB0 YF410C T13 PC4 T13 PM4 TS410-FB0	F, H-Fil	CO_2 / Ar+20%CO_2	DC(+)	0.07	0.28	0.35	0.012	0.005	12.9	-	-	530	28	PWHT : 750×1hr. S.R.	K-410T is designed for MAG welding of martensite stainless alloys of the 13%Cr types and used for surfacing of sealing faces of valves for gas, water, and steam piping system at service temperatures up to 450℃. Wire is a metal type of flux cored wire for flat and horizontal position welding.	-

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							C	Si	Mn	P	S	Cr	Ni	Mo	T.S (MPa)	El. (%)	I.V (J)		
K-410NiMoT	1.2~1.6	AWS A5.2 JIS Z3323 EN ISO 17633-A EN ISO 17633-B	E410NiMoT0-4 TS410NiMo-FM0 T13 4 PM4 TS410NiMo-FM0	F, H-Fil	Ar+20%CO_2	DC(+)	0.04	0.23	0.36	0.010	0.007	12.2	4.1	0.7	900	18	PWHT : 600×1hr. S.R.	K-410NiMoT is designed for MAG welding of soft-martensite stainless alloys of the 13%Cr-4%Ni-Mo types. (AISI 403, 405, 410, 420, JIS SCS3, SCS6, ASTMCA15M, CA6NM) Wire is a metal type of flux cored wire for flat and horizontal position welding.	CE, JIS
K-410NiMoTC	1.2~1.6	AWS A5.22 JIS Z3323 EN ISO 17633-A EN ISO 17633-B	E410NiMoT1-1 TS410NiMo-FC1 T13 4 PC1 TS410NiMo-FC1	F, V, OH H, VD	CO_2	DC(+)	0.04	0.55	0.45	0.010	0.008	12.2	4.8	0.6	950	18	PWHT : 600×1hr. S.R.	K-410NiMoTC is designed for MAG welding of soft-martensite stainless alloys of the 13%Cr-4%Ni-Mo types (AISI 403, 405, 410, JIS SCS3, SCS6, SB410, ASTM CA15M, CA6NM) Wire is a titania type of flux cored wire for all-position welding with 100% CO_2 gas.	CE, JIS