



CEWELD SACW 410 NiMoN

TYPE Tubular wire based on a 13% Chromium and 4% Nickel deposit stabilized with Niobium.

APPLICATIONS Cladding wear resistant overlays in steel mills and applications of the same kind.

PROPRIÉTÉS Higher productivity, higher deposition rates and improved wetting properties compared to solid wires with comparable analysis. Attractive bead appearance without slag residues. Hard facing alloy with excellent thermo shock resistance and increased hardness due to additions of Vanadium and Niobium. Best to be used with FL 915 or FL 8111 welding flux.

CLASSIFICATION AWS A 5.9: ER410NiMo
EN ISO 14700: T Fe7

CONVIENT POUR **13%Cr - 4%Ni - 0,5%Mo Steel**
1.4000, 1.4001, 1.4002, 1.4313, 1.4317, 1.4407, 1.4413, 1.4414,
GX4CrNi13-4, X3CrNiMo13-4, GX5CrNiMo13-4, GX4CrNiMo13-4, X 6 Cr 13, X 7 Cr 14, X 6 CrAl 13
ACI Gr. CA 6 NM

AGRÉMENTS

POSITIONS DE SOUDAGE



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Ni	Mo	N
0.06	0.5	0.6	12.5	4.4	0.5	0.1

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A5 (%)	Hardness
As Welded		>760	>15	45 HRc

ETUVAGE Not required

GAS ACC. EN ISO 14175