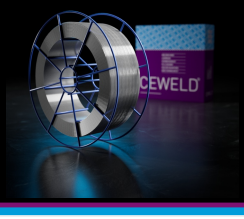


CEWELD 410

certilas® THE FILLER METAL SPECIALIST

TYPE

Solid stainless steel welding wire

TOEPASSINGEN

Overlay of carbon and low-alloy steels for resistance to corrosion, erosion, or abrasion. 410 has higher hardness and is used in valve seats to obtain better galling resistance. Normally to obtain adequate ductility, preheat and post-weld heat-treatment are required.

EIGENSCHAPPEN

CEWELD 410 is a martensitic stainless steel that is heat-treatable. It has a nominal weld metal composition of 12% Chromium. These weld deposits are air-hardenable that can normally be heat-treated after welding.

CLASSIFICATIE

AWS	A 5.9: ER410
EN ISO	14343-A: G Z 13
W.Nr.	1.4009
F-nr	6
FM	5

GESCHIKT VOOR

Ferritic 13 % Chrome steel,
1.4000, 1.4001, 1.4002, 1.4003, 1.4006, 1.4008, 1.4021, 1.4024,
X6Cr13, X6CrAl13, X10Cr13, X15Cr13, X20Cr13, G-X10Cr13, X7Cr14, X6CrAl13, X 20Cr13, X15Cr13
AISI 410, 420

GOEDKEURINGEN

CE

LASPOSITIES

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	P	S	Cr	Ni	Mo	Nb	N	Cu
0.1	0.25	0.4	0.02	0.001	12.5	0.2	0.04	0.01	0.04	0.05

MECHANISCHE WAARDEN

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded	420	650	18	30 HRc

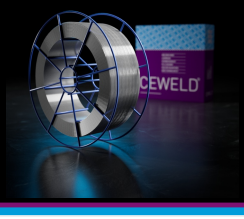
HERDROGEN

350°C / 2 hr

=(+)

GAS ACC. EN ISO 14175

M21, M11, C1, M23, M32



CEWELD 410

410 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663411884

410 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663411891

410 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663411907