



CEWELD SACW 410 NiMoN

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

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

EIGENSCHAFTEN 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.

KLASSIFIKATION

AWS	A 5.9: ER410NiMo
EN ISO	14700: T Fe7

GEEIGNET FÜR **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

ZULASSUNGEN

SCHWEISSPOSITIONEN



**TYPISCHE CHEMISCHE
ANALYSE DES
SCHWEISSMETALLS (%)**

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

MECHANISCHE GÜTEWERTE

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

RÜCKTROCKNUNG Not required

GAS ACC. EN ISO 14175