



CEWELD 4009 Ti

TYPE	Basic coated rod electrode with approx. 13% Cr. (type E410, 1.4009)					
APPLICATIONS	CEWELD® 4009 Ti can be used for welding martensitic-ferritic steels and cast steel. Predominantly for build-ups, corrosion-resistant and wear-resistant layers. Preferred applications are sealing surfaces on gas, water and steam fittings at operating temperatures of up to 450°C.					
PROPERTIES	CEWELD® E 4009 Ti can be used for a working temperature of up to 450°C. The recommended preheat temperature is 200°C - 300°C unless the base material requires a higher preheat temperature. Use DC+ polarity and min 2 layers are required. A tempering of 700 - 750°C is possible if required.					
CLASSIFICATION	AWS	A 5.4: E 410-26				
	EN ISO	3581-A: E 13 B 42				
	W.Nr.	1.4009				
	F-nr	1				
	FM	5				
SUITABLE FOR	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 AISI 410, 420					
APPROVALS	CE					
WELDING POSITIONS	 PA  PB  PC  PF					
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	Cr	Ni	Mo
	0.1	0.6	0.7	13	0.2	0.5
MECHANICAL PROPERTIES	Heat Treatment		R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
	725°C- 755°C 1h		500	650	21	180 HB
	As Welded		550	800	10	300 HV
REDRYING	300°C / 2 hr					
GAS ACC. EN ISO 14175						



CEWELD 4009 Ti

4009 Ti 2,5 X 300MM

Packaging	KG/unit	EanCode
Can	2,5	8720663400710

4009 Ti 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2,6	8720663400727

4009 Ti 4,0 X 350MM

Packaging	KG/unit	EanCode
Can	2,6	8720663400734