



CEWELD SACW 410 NiMoN

TYPE	Tubular wire based on a 13% Chromium and 4% Nickel deposit stabilized with Niobiumn.						
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 EN ISO	A 5.9: ER410NiMo 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	PA PB PC						
ANALYSE CHIMIQUE TYPIQUE DU MÉTAL DE SOUDURE (%)	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							