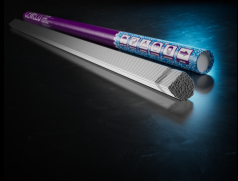




# CEWELD 410 Tig

|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                               |                      |                    |          |
|---------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------|----------------------|--------------------|----------|
| TYPE                                              | Stainless steel filler with 13% chromium for overlay welding and joining.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                               |                      |                    |          |
| TOEPASSINGEN                                      | Overlay of carbon and low-alloy steels for resistance to corrosion, erosion, or abrasion. CEWELD® 410 Tig 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 Tig 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                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | 14700: S Fe7, 14343-A: W Z 13 |                      |                    |          |
|                                                   | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | 1.4009                        |                      |                    |          |
|                                                   | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | 6                             |                      |                    |          |
|                                                   | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | 5                             |                      |                    |          |
| GESCHIKT VOOR                                     | Ferritic 13 % Chrome steel,<br>1.4000, 1.4001, 1.4002, 1.4003, 1.4006, 1.4008, 1.4021, 1.4024,<br>X6Cr13, X6CrAl13, X10Cr13, X15Cr13, X20Cr13, G-X10Cr13, X7Cr14, X6CrAl13, X 20Cr13, X15Cr13<br>AISI 410, 420                                                                                                                                                                                                                                                                                                                                                                                       |                               |                      |                    |          |
| GOEDKEURINGEN                                     | CE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                               |                      |                    |          |
| LASPOSITIES                                       |        |                               |                      |                    |          |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | Mn                            | Cr                   | Ni                 | Mo       |
|                                                   | 0.02                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | 0.5                           | 13                   | 0.3                | 0.03     |
| MECHANISCHE WAARDEN                               | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | R <sub>p0,2</sub> (MPa)       | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Hardness |
|                                                   | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | 420                           | 650                  | 15                 | 35 HRc   |
| HERDROGEN                                         | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                               |                      |                    |          |
| HARDNESS                                          | Hardness after PWHT: 180HB                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                               |                      |                    |          |
| GAS ACC. EN ISO 14175                             | I1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                               |                      |                    |          |



# CEWELD 410 Tig

410 TIG 1,0 X 1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663411914 |

410 TIG 1,2 X 1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663411921 |

410 TIG 1,6 X 1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663412867 |

410 TIG 2,0 X 1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663412874 |

410 TIG 2,4 X 1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663411938 |

410 TIG 3,2 X 1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663411945 |