



CEWELD SACW 410 NiMoN

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

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

PROPERTIES 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	A 5.9: ER410NiMo
EN ISO	14700: T Fe7

SUITABLE FOR **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

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

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

MECHANICAL PROPERTIES

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

REDRYING Not required

GAS ACC. EN ISO 14175