



# 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,<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<br>AISI 410, 420                                                                                                                                                                                          |                   |                         |                      |                    |          |
| APPROVALS                                   | CE                                                                                                                                                                                                                                                                                                                                                                 |                   |                         |                      |                    |          |
| WELDING POSITIONS                           | <div> PA  PB  PC  PF</div> |                   |                         |                      |                    |          |
| 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 <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | 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 |