



# 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.                                                                                                                                                                                                                                                                              |  |  |
| 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 | <b>13%Cr - 4%Ni - 0.5%Mo Steel</b><br>1.4000, 1.4001, 1.4002, 1.4313, 1.4317, 1.4407, 1.4413, 1.4414,<br>GX4CrNi13-4, X3CrNiMo13-4, GX5CrNiMo13-4, GX4CrNiMo13-4, X 6 Cr 13, X 7 Cr 14, X 6 CrAl 13<br>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 <sub>p0.2</sub><br>(MPa) | R <sub>m</sub><br>(MPa) | A5<br>(%) | Hardness |
|----------------|----------------------------|-------------------------|-----------|----------|
| As Welded      |                            | >760                    | >15       | 45 HRc   |

|          |              |
|----------|--------------|
| REDRYING | Not required |
|----------|--------------|

GAS ACC. EN ISO 14175