



CEWELD SACW 4115

TYPE Tubular SAW wire based on a 17% Chromium deposit with high Carbon content..

APPLICATIONS Hardfacing shafts from stainless steel parts, molt repairs, rebuilding pump parts, etc. Suitable for plating and joining equal and similar ferritic Cr-steels and cast steels. Proper weldings are subject to the recommended heat treatment. This welding wire is specially suitable for sealing surfaces on water-, steam and gas-valves, especially for sulphuric gases.

PROPERTIES Higher productivity, higher deposition rates and improved wetting properties compared to solid wires with comparable analysis. Best to be used with CEWELD® FL 915 or CEWELD® FL 8111 welding flux. The deposit is resistant to seawater, thin acids and scale resistant in air and oxidizing gases up to 950°C. The weld deposit can be tempered.

CLASSIFICATION EN ISO 14700: T Fe8
W.Nr. 1.4115

SUITABLE FOR 1.4122, 1.4115 (G)X35CrMo17, 1.4313, 1.4000, 1.4001, 1.4002, Cast steels

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Mn	Si	Cr	Mo
0.2	0.85	0.45	17	1

MECHANICAL PROPERTIES

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded				43 HRc

REDRYING Not required

GAS ACC. EN ISO 14175