



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	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
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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
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GAS ACC. EN ISO 14175