



CEWELD SACW 410 NiMoN

TYPE	Tubular wire based on a 13% Chromium and 4% Nickel deposit stabilized with Niobiumn.						
ANWENDUNGEN	Cladding wear resistant overlays in steel mills and applications of the same kind.						
EIGENSCHAFTEN	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.						
KLASSIFIKATION	AWS EN ISO		A 5.9: ER410NiMo 14700: T Fe7				
GEEIGNET FÜR	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						
ZULASSUNGEN							
SCHWEISSPOSITIONEN	 PA  PB  PC						
TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%)	C	Si	Mn	Cr	Ni	Mo	N
	0.06	0.5	0.6	12.5	4.4	0.5	0.1
MECHANISCHE GÜTEWERTE	Heat Treatment		R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Hardness	
	As Welded			>760	>15	45 HRc	
RÜCKTROCKNUNG	Not required						
GAS ACC. EN ISO 14175							