








CEWELD 410 Tig

TYPE	Stainless steel filler with 13% chromium for overlay welding and joining.				
APPLICATIONS	Overlay of carbon and low-alloy steels for resistance to corrosion, erosion, or abrasion. CEWELD® 410 Tig has higher hardness and is used in valve seats to obtain better galling resistance. Normally to obtain adequate ductility, preheat and post-weld heat-treatment are required.				
PROPERTIES	CEWELD® 410 Tig is a martensitic stainless steel that is heat-treatable. It has a nominal weld metal composition of 12% Chromium. These weld deposits are air-hardenable that can normally be heat-treated after welding.				
CLASSIFICATION	AWS	A 5.9: ER410			
	EN ISO	14700: S Fe7			
	DIN	8555: TIG 5-GZ-CGTZ			
	W.Nr.	1.4009			
	F-nr	6			
	FM	5			
SUITABLE FOR	Ferritic 13 % Chrome steel, 1.4000, 1.4001, 1.4002, 1.4003, 1.4006, 1.4008, 1.4021, 1.4024, X6Cr13, X6CrAl13, X10Cr13, X15Cr13, X20Cr13, G-X10Cr13 AISI 410, 420				
APPROVALS	CE				
WELDING POSITIONS	      				
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Mn	Cr	Ni	Mo
	0.02	0.5	13	0.3	0.03
MECHANICAL PROPERTIES	Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
	As Welded	420	650	15	35 HRc
REDRYING	Not required				
HARDNESS	Hardness after PWHT: 180HB				
GAS ACC. EN ISO 14175	I1				



CEWELD 410 Tig

410 TIG 1,0 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663411914

410 TIG 1,2 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663411921

410 TIG 1,6 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663412867

410 TIG 2,0 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663412874

410 TIG 2,4 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663411938

410 TIG 3,2 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663411945