



# CEWELD SACW 410 NiMoN

**TYPE** Tubular wire based on a 13% Chromium and 4% Nickel deposit stabilized with Niobium.

**APPLICATIONS** Cladding wear resistant overlays in steel mills and applications of the same kind.

**PROPRIÉTÉS** 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

**CONVIENT POUR** **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

**AGRÉMENTS**

**POSITIONS DE SOUDAGE**



**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

**PROPRIÉTÉS MÉCANIQUES**

Heat Treatment	R <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A5 (%)	Hardness
As Welded		>760	>15	45 HRc

**ETUVAGE** Not required

**GAS ACC. EN ISO 14175**