



CEWELD SACW 410

NiMoNbV

TYPE	Tubular SAW wire based on a 13% Chromium deposit for cladding components against corrosion, heat and wear.		
APPLICATIONS	Rebuilding and cladding applications against thermal shock offering a fair corrosion resistance and excellent resistance against thermal fatigue at high temperatures.		
PROPERTIES	High productivity, high deposition rates and improved wetting properties compared to solid wires with similar analysis. Attractive bead appearance without slag residues. Best to be used with welding flux FL 915 or FL 8111		
CLASSIFICATION	AWS EN ISO	A 5.9: EC410NiMo 14700: T Fe7	
SUITABLE FOR	1.4317, 1.4313, 1.4407, 1.4414, GX4CrNi13-4, X3CrNiMo13-4, GX5CrNiMo13-4, GX4CrNiMo13-4 ACI Gr. CA 6 NM		

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Ni	Mo	Nb	V
0.06	0.5	0.6	12.5	4.5	0.5	0.12	0.15

MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} (MPa)	R _m (MPa)	A5 (%)	Hardness
As Welded		>760	>15	42 HRc

REDRYING Not required

GAS ACC. EN ISO 14175



CEWELD SACW 410 NiMoNbV

SACW 410 NIMONBV 2,4MM	Packaging	KG/unit	EanCode
	Drum	300	8720663413833
SACW 410 NIMONBV 2,8MM	Packaging	KG/unit	EanCode
	Drum	300	8720663404763
SACW 410 NIMONBV 3,2MM	Packaging	KG/unit	EanCode
	Drum	300	8720663404787
	K-415	25	8720663404770