





CEWELD SACW 4115

TYPE	Tubular SAW wire based on a 17% Chromium deposit with high Carbon content..				
APPLICATIONS	Hardfacing shafts from stainless steel parts, molt repairs, rebuilding pump parts, etc. Suitable for plating and joining equal and similar ferritic Cr-steels and cast steels. Proper weldings are subject to the recommended heat treatment. This welding wire is specially suitable for sealing surfaces on water-, steam and gas-valves, especially for sulphuric gases.				
PROPERTIES	Higher productivity, higher deposition rates and improved wetting properties compared to solid wires with comparable analysis. Best to be used with CEWELD® FL 915 or CEWELD® FL 8111 welding flux.The deposit is resistant to seawater, thin acids and scale resistant in air and oxidizing gases up to 950°C. The weld deposit can be tempered.				
CLASSIFICATION	EN ISO W.Nr.	14700: T Fe8 1.4115			
SUITABLE FOR	1.4122, 1.4115 (G)X35CrMo17, 1.4313, 1.4000, 1.4001, 1.4002, Cast steels				
APPROVALS	No Approvals Found				
WELDING POSITIONS	<div> </div>				
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Mn	Si	Cr	Mo
	0.2	0.85	0.45	17	1
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} MPa	R _m MPa	A ₅ (%)	Hardness Rockwell C
	As Welded /				Avg. 43
REDRYING TEMPERATURE	Not required				
GAS ACCORDING EN 14175					