




CEWELD AA 410

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|---------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------|--------------------|--------------------|---------------------------|-----|
| TYPE | AA 410 is a stainless flux cored wire for Hardfacing. | | | | | |
| APPLICATIONS | Overlay of carbon and low-alloy steels for resistance to corrosion, erosion, or abrasion. | | | | | |
| PROPERTIES | AA 410 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 . AA 410 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 5.22: E410T0-4 | | | | |
| | EN ISO | 14700: T Fe7 | | | | |
| | W.Nr. | 1.4009 | | | | |
| SUITABLE FOR | 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 | No Approvals Found | | | | | |
| WELDING POSITIONS | <div> PA</div> <div> PB</div> <div> PC</div> | | | | | |
| TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%) | C | Si | Mn | P | Cr | Mo |
| | 0.12 | 0.8 | 1.2 | 0.015 | 13.5 | 0.5 |
| ALL WELD MECHANICAL PROPERTIES | Heat Treatment | R _{p0,2} MPa | R _m MPa | A ₅ (%) | Hardness Brinell Hardness | |
| | As Welded / | | | | Avg. 330 | |
| REDRYING TEMPERATURE | Not required | | | | | |
| GAS ACCORDING EN 14175 | M21 | | | | | |



CEWELD AA 410

AA 410 1,2MM

| Type | KG/unit | EANCode |
|--------|---------|---------------|
| BS-300 | 15 | 8720663413826 |