










CEWELD 410

TYPE	Solid stainless steel welding wire										
APPLICATIONS	Overlay of carbon and low-alloy steels for resistance to corrosion, erosion, or abrasion. 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.										
PROPERTIES	CEWELD 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 5.9: ER410									
	EN ISO	14343-A: G Z 13									
	DIN	8555: MSG 5-GZ-CGTZ									
	F-nr	6									
	FM	5									
	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	CE										
WELDING POSITIONS	<div> PA</div> <div> PB</div> <div> PC</div> <div> PD</div> <div> PE</div> <div> PF</div> <div> PG</div>										
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	P	S	Cr	Ni	Mo	Nb	N	Cu
	0.1	0.25	0.4	0.02	0.001	12.5	0.2	0.04	0.01	0.04	0.05
ALL WELD MECHANICAL PROPERTIES	Heat Treatment		R _{P0,2} MPa	R _m MPa	A5 (%)			Hardness Rockwell C			
	As Welded /1h		400	600	22			Avg. 35			
REDRYING TEMPERATURE	Not required										
GAS ACCORDING EN 14175	M20, M21, M11, C1										



CEWELD 410

410 1,0MM

Type	KG/unit	EANCode
BS-300	15	8720663411884

410 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663411891

410 1,6MM

Type	KG/unit	EANCode
BS-300	15	8720663411907