

SACW 410 NiMo

CATEGORY	SAW Submerged arc
TYPE	Tubular wire based on a 13% Chromium and 4% Nickel deposit for cladding components against corrosion, heat and wear resistance.
APPLICATIONS	Rebuilding and cladding applications against thermal shock offering a fair corrosion resistance.
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
CLASSIFICATION	AWS A 5.9: EN ISO 14700: T Fe7
SUITABLE FOR	Steel mill rollers, turbine components, shafts etc..
APPROVALS	CE approved

WELDING POSITIONS:



C	Mn	Si	Cr	Ni	Mo
0.05-0.07	0.5-0.7	0,4-0,6	12-14	3.7-4.3	0.9-1.3

ALL WELD METAL PROPERTIES WITH FL 915

Hardnes test HRc				
as welded	tempered 525°C	tempered 550°C	tempered 575°C	tempered 600°C
43-47	40-44	37-41	33-37	30-34

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet
1.6			Coil / Drum	25 / 300	
2.4			Coil / Drum	25 / 300	
3.2			Coil / Drum	25 / 300	

REDRYING TEMPERATURE 150°C / 24hr