CEWELD®

SACW 410 NiMoNbN

CATEGORY	SAW Submerged arc
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 excelent resistance against thermal fatique 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 880
CLASSIFICATION	AWS A 5.9: EN ISO 14700: ~T Fe8 DIN 8555: UP 5-GF-50-C
SUITABLE FOR	Steel mill rollers, turbine components, shafts etc..
APPROVALS	CE approved
WELDING POSITIONS:	

WELD DEPOSIT ANALYSIS % (TYPICAL WITH FL 915)

C	Mn	Si	Cr	Ni	Mo	Nb	N
<0,1	1,0-1,4	<0,45	13,0-15,0	3,0-4,0	1,3-1,6	2X(C)	0,10

ALL WELD METAL PROPERTIES WITH FL 915

Hardnes test HRc				
as welded	tempered 525°C	tempered 550°C	tempered 575°C	tempered 600°C
48-52				

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool / drum	kg / pallet
1.6	27-29	250-350	Coil / Drum	25 / 300	
2.4	28-32	300-450	Coil / Drum	25 / 300	
3.2	29-34	350-550	Coil / Drum	25 / 300	

REDRYING TEMPERATURE	150°C / 24hr