



# CEWELD SACW 4115

|   |  |                  |          |        |          |  |  |  |  |
|---|--|------------------|----------|--------|----------|--|--|--|--|
| TYPE  | Tubular SAW wire based on a 17% Chromium deposit with high Carbon content..  |                  |          |        |          |  |  |  |  |
| TOEPASSINGEN                                | Hardfacing shafts from stainless steel parts, melt 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.        |                  |          |        |          |  |  |  |  |
| EIGENSCHAPPEN                               | Higher productivity, higher deposition rates and improved wetting properties compared to solid wires with comparable analysis. Best to be used with <a href="#">CEWELD® FL 915</a> or <a href="#">CEWELD® FL 8111</a> 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. |                  |          |        |          |  |  |  |  |
| CLASSIFICATIE                               | EN ISO   | 14700: T Fe8     |          |        |          |  |  |  |  |
|   | W.Nr.  | 1.4115           |          |        |          |  |  |  |  |
| GESCHIKT VOOR                               | 1.4122, 1.4115 (G)X35CrMo17, 1.4313, 1.4000, 1.4001, 1.4002, Cast steels   |                  |          |        |          |  |  |  |  |
| GOEDKEURINGEN                               |  |                  |          |        |          |  |  |  |  |
| LASPOSITIONS                                |  PA  PB  |                  |          |        |          |  |  |  |  |
| TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%) | C  | Mn               | Si       | Cr     | Mo       |  |  |  |  |
|   | 0.2  | 0.85             | 0.45     | 17     | 1        |  |  |  |  |
| MECHANISCHE WAARDEN                         | Heat Treatment   | $R_{P0.2}$ (MPa) | Rm (MPa) | A5 (%) | Hardness |  |  |  |  |
|   | As Welded  |                  |          |        | 43 HRc   |  |  |  |  |
| HERDROGEN                                   | Not required   |                  |          |        |          |  |  |  |  |

GAS ACC. EN ISO 14175