CEWELD 410 Tig

certilas® THE FILLER METAL SPECIALIST

TYPE

Stainless steel filler with 13% chromium for overlay welding and joining.

TOEPASSINGEN

Overlay of carbon and low-alloy steels for resistance to corrosion, erosion, or abrasion. CEWELD® 410 Tig 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.

EIGENSCHAPPEN

CEWELD® 410 Tig 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.

CLASSIFICATIE

AWS	A 5.9: ER410
EN ISO	14700: S Fe7, 14343-A: W Z 13
W.Nr.	1.4009
F-nr	6
FM	5

GESCHIKT VOOR

Ferritic 13 % Chrome steel,
1.4000, 1.4001, 1.4002, 1.4003, 1.4006, 1.4008, 1.4021, 1.4024,
X6Cr13, X6CrAl13, X10Cr13, X15Cr13, X20Cr13, G-X10Cr13, X7Cr14, X6CrAl13, X 20Cr13, X15Cr13
AISI 410, 420

GOEDKEURINGEN

CE

LASPOSITIES

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Mn	Cr	Ni	Mo
0.02	0.5	13	0.3	0.03

MECHANISCHE WAARDEN

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded	420	650	15	35 HRc

HERDROGEN

Not required

HARDNESS

Hardness after PWHT: 180HB

GAS ACC. EN ISO 14175

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410 TIG 1,0 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663411914

410 TIG 1,2 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663411921

410 TIG 1,6 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663412867

410 TIG 2,0 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663412874

410 TIG 2,4 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663411938

410 TIG 3,2 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663411945