



# CEWELD AA 410

**TYPE** CEWELD® AA 410 is a stainless flux cored wire for Hardfacing.(13% Cr Steel)

**APPLICATIONS** Overlay of carbon and low-alloy steels for resistance to corrosion, erosion, or abrasion.

**PROPERTIES** **CEWELD® AA 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 . **CEWELD® AA 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 5.22: E410T0-4 |
| EN ISO | 14700: T Fe7     |
| W.Nr.  | 1.4009           |

**SUITABLE FOR** **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  
AISI 410, 420

**APPROVALS**

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

| C    | Si  | Mn  | P     | Cr   | Mo  |
|------|-----|-----|-------|------|-----|
| 0.12 | 0.8 | 1.2 | 0.015 | 13.5 | 0.5 |

**MECHANICAL PROPERTIES**

| Heat Treatment | R <sub>P0.2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Hardness |
|----------------|-------------------------|----------------------|--------------------|----------|
| As Welded      |                         |                      |                    | 330 HB   |

**REDRYING** Not required

**GAS ACC. EN ISO 14175** M21



# CEWELD AA 410

AA 410 1,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663413826 |