



CEWELD 410

TYPE	Solid stainless steel welding wire. (410, 13% Cr Steel)										
APPLICATIONS	CEWELD® 410 is used to overlay carbon and low-alloy steels to provide corrosion, erosion and abrasion resistance. CEWELD® 410 is harder and is used in valve seats to improve galling resistance. To obtain adequate ductility, preheating and post-weld heat treatment are normally required.										
PROPERTIES	CEWELD® 410 is a heat-treatable martensitic stainless steel. It has a nominal weld metal composition of 13% chromium. These air-hardenable weld deposits can normally be heat-treated after welding for service temperatures of up to 450°C. =(+)										
CLASSIFICATION	AWS	A 5.9: ER410									
	EN ISO	14343-A: G Z 13									
	W.Nr.	1.4009									
	F-nr	6									
	FM	5									
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, X7Cr14, X6CrAl13, X 20Cr13, X15Cr13 AISI 410, 420										
APPROVALS	CE										
WELDING POSITIONS	      										
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	P	S	Cr	Ni	Mo	Nb	N	Cu
	0.1	0.25	0.4	0.02	0.001	12.5	0.2	0.04	0.01	0.04	0.05
MECHANICAL PROPERTIES	Heat Treatment			R _{p0.2} (MPa)		R _m (MPa)		A ₅ (%)	Hardness		
	As Welded			420		650		18	30 HRc		
REDRYING	Not required										
=(+)											
GAS ACC. EN ISO 14175	M21, M11, C1, M23, M32										



CEWELD 410

410 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663411884

410 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663411891

410 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663411907