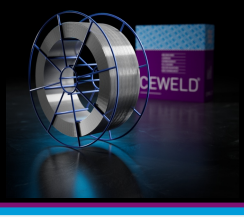


CEWELD 410

certilas® THE FILLER METAL SPECIALIST

TYPE	Solid stainless steel welding wire. (13% Cr Steel)
APPLICATIONS	Overlay of carbon and low-alloy steels for resistance to corrosion, erosion, or abrasion. 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.
PROPERTIES	**CEWELD® 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 5.9: ER410
EN ISO	14343-A: G Z 13
DIN	8555: MSG 5-GZ-CGTZ
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
AISI 410, 420

APPROVALS: CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

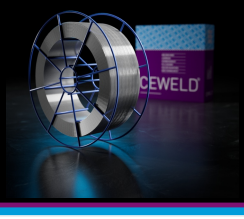
C	Si	Mn	P	S	Cr	Ni	Mo	Nb	N	Cu
0.1	0.25	0.4	0.02	0.001	12.5	0.2	0.04	0.01	0.04	0.05

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded	400	600	22	35 HRc

REDRYING: Not required

GAS ACC. EN ISO 14175: M20, M21, M11, C1



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