

SACW 410 NiMo

CATEGORY SAW Arc Submerged

TYPE Tubular wire based on a 13% Chromium and 4% Nickel deposit for cladding components against corrosion, heat and wear resistance.

APPLICATIONS Rebuilding and cladding applications against thermal shock offering a fair corrosion resistance.

PROPERTIES High productivity, high deposition rates and improved wetting properties compared to solid wires with similar analysis. Attractive bead appearance without slag residues. Best to be used with welding flux [FL 915](#)

CLASSIFICATION AWS A 5.9:
EN ISO 14700: T Fe7

SUITABLE FOR Steel mill rollers, turbine components, shafts etc..

APPROVALS CE approved

WELDING POSITIONS:



C	Mn	Si	Cr	Ni	Mo
0.05-0.07	0.5-0.7	0,4-0,6	12-14	3.7-4.3	0.9-1.3

ALL WELD METAL PROPERTIES WITH FL 915

as welded	tempered 525°C	Hardnes test HRC		
		tempered 550°C	tempered 575°C	tempered 600°C
43-47	40-44	37-41	33-37	30-34

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet
1.6			Coil / Drum	25 / 300	
2.4			Coil / Drum	25 / 300	
3.2			Coil / Drum	25 / 300	

REDRYING TEMPERATURE 150°C / 24hr