

SACW 410 NiMo N

CATEGORY SAW Arc Submerged

TYPE Tubular wire based on a 13% Chromium and 4% Nickel deposit with nitrogen.

APPLICATIONS Cladding wear resistant overlays in steel mills and applications of the same kind.

PROPERTIES Higher productivity, higher deposition rates and improved wetting properties compared to solid wires with comparable analysis. Attractive bead appearance without slag residues. Hard facing alloy with excellent thermo shock resistance and increased hardness due to additions of Nitrogen. Best to be used with **FL 915** welding flux.

CLASSIFICATION

AWS	A5.9:
EN ISO	14700: T Fe7
DIN	8555: UP 5-GF-40-C

SUITABLE FOR Steel mill rollers, hot rolling equipment, bars.

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Mn	Si	Cr	Ni	Mo	N
0.08	1.0	0.30	13.5	4.3	0.50	0.1

MECHANICAL PROPERTIES

Heat Treatment	Rp0,2 (N/mm ²)	Rm (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V			Hardness HRC
				-20°C	-40°C	-60°C	
AW							43

AW: as welded

WELDING PARAMETERS / PACKING

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

REDRYING TEMPERATURE 150`C / 24hr