

SACW 410 NiMoNbV

CATEGORY SAW Arc Submerged

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

APPLICATIONS Rebuilding and cladding applications against thermal shock offering a fair corrosion resistance and excellent resistance against thermal fatigue at high temperatures.

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** or **FL 8111**

CLASSIFICATION

AWS	A 5.9:
EN ISO	14700: ~T Fe8
DIN	8555: UP 5-GF-50-C

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

APPROVALS CE approved

WELDING POSITIONS:



WELD DEPOSIT ANALYSIS % (TYPICAL WITH FL 915)

C	Mn	Si	Cr	Ni	Mo	Nb	V
<0,1	1,0-2,0	<0,7	11,0-13,5	3,0-4,0	1,0-1,5	2X(C)	0,15

ALL WELD METAL PROPERTIES WITH FL 915

Hardnes test HRc				
as welded	tempered 525°C	tempered 550°C	tempered 575°C	tempered 600°C
40-44				

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool / drum	kg / pallet
1.6	27-29	250-350	Coil / Drum	25 / 300	
2.4	28-32	300-450	Coil / Drum	25 / 300	
3.2	29-34	350-550	Coil / Drum	25 / 300	

REDRYING TEMPERATURE 150°C / 24hr