



# CEWELD SACW 4115

TYPE	Tubular SAW wire based on a 17% Chromium deposit with high Carbon content..														
APPLICATIONS	Hardfacing shafts from stainless steel parts, melt repairs, rebuilding pump parts, etc. Suitable for plating and joining equal and similar ferritic Cr-steels and cast steels. Proper weldings are subject to the recommended heat treatment. This welding wire is specially suitable for sealing surfaces on water-, steam and gas-valves, especially for sulphuric gases.														
PROPERTIES	Higher productivity, higher deposition rates and improved wetting properties compared to solid wires with comparable analysis. Best to be used with <a href="#">CEWELD® FL 915</a> or <a href="#">CEWELD® FL 8111</a> welding flux. The deposit is resistant to seawater, thin acids and scale resistant in air and oxidizing gases up to 950°C. The weld deposit can be tempered.														
CLASSIFICATION	EN ISO 14700: T Fe8 W.Nr. 1.4115														
SUITABLE FOR	1.4122, 1.4115 (G)X35CrMo17, 1.4313, 1.4000, 1.4001, 1.4002, Cast steels														
APPROVALS															
WELDING POSITIONS	 PA  PB														
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table><tr><td>C</td><td>Mn</td><td>Si</td><td>Cr</td><td>Mo</td></tr><tr><td>0.2</td><td>0.85</td><td>0.45</td><td>17</td><td>1</td></tr></table>					C	Mn	Si	Cr	Mo	0.2	0.85	0.45	17	1
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MECHANICAL PROPERTIES	<table><tr><td>Heat Treatment</td><td><math>R_{P0.2}</math> (MPa)</td><td><math>R_m</math> (MPa)</td><td>A5 (%)</td><td>Hardness</td></tr><tr><td>As Welded</td><td></td><td></td><td></td><td>43 HRc</td></tr></table>					Heat Treatment	$R_{P0.2}$ (MPa)	$R_m$ (MPa)	A5 (%)	Hardness	As Welded				43 HRc
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As Welded				43 HRc											
REDRYING	Not required														

GAS ACC. EN ISO 14175