CEWELD AA M410 NiMo

certilas® THE FILLER METAL SPECIALIST

TYPE

Metal cored CrNiMo alloyed welding wire for rebuilding and cladding

APPLICATIONS

AA M410NiMo is a Cr-Ni-Mo- alloyed, gas-shielded metal-cored wire electrode for cladding. The corrosion resistant deposit offers a medium hardness and is resistant against metal-metal wear and high surface pressure. He is used in steel mill rollers, thermoshock resistant and suitable for Francis and Pelton turbines. Used in steam power plants for its excelent resistance to cavitation and stress corrosion cracking.

PROPERTIES

Good corrosion and abrasion resistance as required by water turbines in hydropower plants.

CLASSIFICATION

AWS	A 5.22: E410NiMoT0-4
EN ISO	17633-A: T 13 4 M M21 2 / T 410NiMo
F-nr	6
FM	5
W.Nr.	1.4313

SUITABLE FOR

13%Cr - 4%Ni - 0,5%Mo Steel
1.4000, 1.4001, 1.4002, 1.4313, 1.4317, 1.4407, 1.4413, 1.4414,
GX4CrNi13-4, X3CrNiMo13-4, GX5CrNiMo13-4, GX4CrNiMo13-4, X 6 Cr 13, X 7 Cr 14, X 6 CrAl 13
ACI Gr. CA 6 NM

APPROVALS

No Approvals Found

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.06	0.8	1	0.015	0.015	12.5	4.5	0.5

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V 0°C	Hardness Rockwell C
As Welded /1h	800	890	19	67	Avg. 40

REDRYING TEMPERATURE

140°C / 24 hr

GAS ACCORDING EN 14175

M21

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AA M410 NIMO 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663411785