



CEWELD 410 NiMo Tig

TYPE	Solid stainless steel wire for joining and cladding.																	
APPLICATIONS	410NiMo Tig is used for welding similar martensitic and martensitic-ferritic steels in different applications, such as hydro turbines.																	
PROPERTIES	Solid welding wire of the 12% Cr, 4.5% Ni, 0.5% Mo type.																	
CLASSIFICATION	AWS	A 5.9: ER410NiMo																
	EN ISO	14343-A: W 13 4																
	F-nr	6																
	FM	5																
	W.Nr.	1.4351																
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	CE																	
WELDING POSITIONS																		
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> </tr> </thead> <tbody> <tr> <td>0.02</td> <td>0.4</td> <td>0.4</td> <td>12</td> <td>4.5</td> <td>0.5</td> </tr> </tbody> </table>		C	Si	Mn	Cr	Ni	Mo	0.02	0.4	0.4	12	4.5	0.5				
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ALL WELD MECHANICAL PROPERTIES	<table border="1"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R_{PO,2} MPa</th> <th rowspan="2">R_m MPa</th> <th rowspan="2">A₅ (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness Brinell Hardness</th> </tr> <tr> <th>RT</th> <th>-20°C</th> </tr> </thead> <tbody> <tr> <td>As Welded / 580°C±15°C /8h</td> <td>650 780</td> <td>790 860</td> <td>18 18</td> <td>50 50</td> <td>40</td> <td>Avg. 38 Avg. 250</td> </tr> </tbody> </table>		Heat Treatment	R _{PO,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V		Hardness Brinell Hardness	RT	-20°C	As Welded / 580°C±15°C /8h	650 780	790 860	18 18	50 50	40	Avg. 38 Avg. 250
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REDRYING TEMPERATURE	Not required																	
GAS ACCORDING EN 14175	I1																	



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410 NIMO TIG 1,6 X 1000MM	Type	KG/unit	EANCode
	Tube	5	8720663411952
410 NIMO TIG 2,0 X 1000MM	Type	KG/unit	EANCode
	Tube	5	8720663411969
410 NIMO TIG 2,4 X 1000MM	Type	KG/unit	EANCode
	Tube	5	8720663411976
410 NIMO TIG 3,2 X 1000MM	Type	KG/unit	EANCode
	Tube	5	8720663411983