



CEWELD 410 NiMo Tig

TYPE Solid stainless steel wire for joining and cladding. (Type410NiMo, 1.4351)

APPLICATIONS CEWELD® 410NiMo Tig is used for welding similar martensitic and martensitic-ferritic steels in various applications such as water turbines, compressor construction, steam power plant construction, continuous casting rolls, centrifuges, valves, Pelton and Francis turbines.

PROPERTIES CEWELD® 410NiMo Tig has comparable properties to steels of the same or similar types. It is resistant to water and steam.
The preheating and interpass temperature should be 100 - 160°C for thick-walled parts.
The heat input should be max. 15 kJ/cm. Annealing at 580 - 620°C is possible.

CLASSIFICATION

AWS	A 5.9: ER410NiMo
EN ISO	14343-A: W 13 4
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 CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	Cr	Ni	Mo
0.02	0.4	0.4	12	4.5	0.5

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{P0,2} 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

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175 I1



CEWELD 410 NiMo Tig

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