



CEWELD AA 410 NiMo

TYPE	Flux cored stainless steel welding wire for rebuilding and cladding against thermal shock. (13 4 Steel)																
APPLICATIONS	Continuous casting rolls, centrifuges, valves, Pelton- and Francis- turbines																
PROPERTIES	Hardfacing alloy for cladding steel mill rollers, thermoshock resistant and suitable for Francis and Pelton turbines. Used in steam power plants for its excellent resistance to cavitation and stress corrosion cracking. CEWELD® AA 410NiMo is a Cr-Ni-Mo- alloyed, gas-shielded flux-cored wire electrode for cladding. The corrosion resistant deposit offers a medium hardness and is resistant against metal-metal wear and high surface pressure.																
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.22: E410NiMoT0-4</td> </tr> <tr> <td>EN ISO</td> <td>14700: T Fe7</td> </tr> <tr> <td>EN ISO</td> <td>17633-A: T 13 4 M M21 2 / T 410NiMo</td> </tr> <tr> <td>W.Nr.</td> <td>1.4351</td> </tr> </table>	AWS	A 5.22: E410NiMoT0-4	EN ISO	14700: T Fe7	EN ISO	17633-A: T 13 4 M M21 2 / T 410NiMo	W.Nr.	1.4351								
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W.Nr.	1.4351																
SUITABLE FOR	<p>13%Cr - 4%Ni - 0,5%Mo Steel</p> <p>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</p>																
APPROVALS	No Approvals Found																
WELDING POSITIONS																	
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>Fe</th> </tr> </thead> <tbody> <tr> <td>0.05</td> <td>0.9</td> <td>0.9</td> <td>0.015</td> <td>13.5</td> <td>4.5</td> <td>0.7</td> <td>Rem.</td> </tr> </tbody> </table>	C	Si	Mn	P	Cr	Ni	Mo	Fe	0.05	0.9	0.9	0.015	13.5	4.5	0.7	Rem.
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ALL WELD MECHANICAL PROPERTIES	<table border="1"> <thead> <tr> <th>Heat Treatment</th> <th>R_{p0,2} MPa</th> <th>R_m MPa</th> <th>A₅ (%)</th> <th>Hardness Rockwell C</th> </tr> </thead> <tbody> <tr> <td>As Welded /</td> <td></td> <td></td> <td></td> <td>Avg. 40</td> </tr> </tbody> </table>	Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	Hardness Rockwell C	As Welded /				Avg. 40						
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REDRYING TEMPERATURE	Not required																
GAS ACCORDING EN 14175	M21																



CEWELD AA 410 NiMo

AA 410 NIMO 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663411761

AA 410 NIMO 2,0MM

Type	KG/unit	EANCode
BS-300	15	8720663411815

AA 410 NIMO 2,4MM

Type	KG/unit	EANCode
BS-300	15	8720663411822