



CEWELD 410 NiMo

TYPE Solid stainless steel wire for joining and cladding.

APPLICATIONS CEWELD® 410NiMo 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 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: G 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 (%)

C	Si	Mn	Cr	Ni	Mo	Cu	Co
0.02	0.4	0.4	12	4.5	0.5	0.07	0.1

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	650 765	790 840	15 18	50 50	40	Avg. 38 Avg. 250

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175 M12



CEWELD 410 NiMo

410 NIMO 1,0MM

Type	KG/unit	EANCode
BS-300	15	8720663411846

410 NIMO 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663411853

410 NIMO 1,6MM

Type	KG/unit	EANCode
BS-300	15	8720663411860