




# CEWELD AA 310 NiMo

TYPE	Flux cored CrNiMo alloyed welding wire for rebuilding and cladding							
APPLICATIONS	CEWELD® AA 310 NiMo is mainly used for roll coatings against hot wear, preferably in steelworks. Continuous casting rolls, steam turbines, valve seats.							
PROPERTIES	<p>CEWELD® AA 310 NiMo produces corrosion-resistant, medium-hardness 13 % Cr weld metal that does not fatigue, even at high temperatures.</p> <p>Heating the high-chromium martensitic alloy allows the hardness to be adjusted precisely within the range of 43–45 HRC.</p> <p>The interpass temperature should not exceed 450°C. The weld metal is tough and can be machined.</p>							
CLASSIFICATION	EN ISO		14700: T Fe7					
SUITABLE FOR	<b>12%Cr - 2%Ni - 1,0%Mo Steel</b> For roll coatings against hot wear, preferably in steelworks. Continuous casting rolls							
APPROVALS	No Approvals Found							
WELDING POSITIONS	<div> PA  PB  PC</div>							
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	Cr	Ni	Mo	Nb	V
	0.12	0.5	1	12	2	1	0.2	0.2
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R <sub>P0,2</sub> MPa	R <sub>m</sub> MPa	A5 (%)			Hardness Rockwell C	
	As Welded /						Avg. 44	
REDRYING TEMPERATURE	Not required							
GAS ACCORDING EN 14175	M21							