

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	12%Cr - 2%Ni - 1,0%Mo Steel For roll coatings against hot wear, preferably in steelworks. Continuous casting rolls																							
APPROVALS	No Approvals Found																							
WELDING POSITIONS	 PA  PB  PC																							
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1"> <thead> <tr> <th>C</th><th>Si</th><th>Mn</th><th>Cr</th><th>Ni</th><th>Mo</th><th>Nb</th><th>V</th></tr> </thead> <tbody> <tr> <td>0.12</td><td>0.5</td><td>1</td><td>12</td><td>2</td><td>1</td><td>0.2</td><td>0.2</td></tr> </tbody> </table>								C	Si	Mn	Cr	Ni	Mo	Nb	V	0.12	0.5	1	12	2	1	0.2	0.2
C	Si	Mn	Cr	Ni	Mo	Nb	V																	
0.12	0.5	1	12	2	1	0.2	0.2																	
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></th><th></th><th></th><th>Hardness Rockwell C</th></tr> </thead> <tbody> <tr> <td>As Welded /</td><td></td><td></td><td></td><td></td><td></td><td></td><td>Avg. 44</td></tr> </tbody> </table>								Heat Treatment	R _{P0,2} MPa	R _m MPa	A ₅ (%)				Hardness Rockwell C	As Welded /							Avg. 44
Heat Treatment	R _{P0,2} MPa	R _m MPa	A ₅ (%)				Hardness Rockwell C																	
As Welded /							Avg. 44																	
REDRYING TEMPERATURE	Not required																							
GAS ACCORDING EN 14175	M21																							