



# 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**

AWS	A 5.22: E410NiMoT0-4
EN ISO	14700: T Fe7
W.Nr.	1.4351

**SUITABLE FOR** **13% Cr- 4%Ni-0,5% Mo Steel**  
 1.4317, 1.4313, 1.4407, 1.4414,  
 GX4CrNi13-4, X3CrNiMo13-4, GX5CrNiMo13-4, GX4CrNiMo13-4  
 ACI Gr. CA 6 NM

**APPROVALS**

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

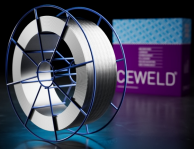
C	Si	Mn	P	Cr	Ni	Mo	Fe
0.05	0.9	0.9	0.015	13.5	4.5	0.7	Rem.

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Hardness
As Welded		>760	>35	40 HRc

**REDRYING** Not required

**GAS ACC. EN ISO 14175** M21



# CEWELD AA 410 NiMo

AA 410 NiMo 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663411761

AA 410 NiMo 2,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663411815

AA 410 NiMo 2,4MM

Packaging	KG/unit	EanCode
BS-300	15	8720663411822