CEWELD AA 410 NiMo

certilas® THE FILLER METAL SPECIALIST

TYPE	Flux cored stainless steel welding wire for rebuilding and cladding against thermal schock. (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 excelent 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	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	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