



CEWELD AA M410 NiMo

TYPE Metal cored CrNiMo alloyed welding wire for rebuilding and cladding

ANWENDUNGEN AA M410NiMo is a Cr-Ni-Mo- alloyed, gas-shielded metal-cored wire electrode for cladding. The corrosion resistant deposit offers a medium hardness and is resistant against metal-metal wear and high surface pressure. He is used in 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.

EIGENSCHAFTEN Good corrosion and abrasion resistance as required by water turbines in hydropower plants.

KLASSIFIKATION

AWS	A 5.22: E410NiMoT0-4
EN ISO	17633-A: T 13 4 M M21 2 / T 410NiMo
W.Nr.	1.4313
F-nr	6
FM	5

GEEIGNET FÜR **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

ZULASSUNGEN

SCHWEISSPOSITIONEN



TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.06	0.8	1	0.015	0.015	12.5	4.5	0.5

MECHANISCHE GÜTEWERTE

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				0°C		
As Welded	800	890	19	67		40 HRc

RÜCKTROCKNUNG 140°C / 24 hr

GAS ACC. EN ISO 14175 M21



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AA M410 NIMO 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663411785