



CEWELD SA 410NiMo

TYPE Solid SAW filler metal for thermal shock resistant overlay welding

APPLICATIONS SA 410NiMo is a stainless solid SAW welding wire of the 12% Cr, 4.5% Ni, 0.5% Mo type. 410NiMo is used for welding similar martensitic and martensitic-ferritic steels in different applications, such as hydro turbines. Water and steam turbine parts of the same kind, thermoshock and high heat resistant. 1.4313, 1.4002, (G)X5CrNi(Mo) 13 4, X6CrAl 13, Grade CA 6 NM.

PROPERTIES Wire with high Chromium content for thermo shock resistance. Fused flux FL 880 or agglomerated flux FL 838 can be used.

CLASSIFICATION	AWS	A 5.9: ER410NiMo
	EN ISO	14343-A: S 13 4
	W.Nr.	1.4313
	F-nr	6
	FM	5

SUITABLE FOR Thermo shock resistant alloy, high temperature resistant, good corrosion resistance

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.02	0.5	0.6	0.02	0.01	12.5	4.8	0.5

MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded	>500	>760	>15	38 HRc

REDRYING Not required

GAS ACC. EN ISO 14175



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SA 410NiMo 1,6MM

Packaging	KG/unit	EanCode
K-415	25	8720663412065