



CEWELD AA 410 NiMo

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, 17633-A: T 13 4 M M21 2 / T 410NiMo							
SUITABLE FOR	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							
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)		R _m (MPa)	A ₅ (%)	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