



CEWELD 410 NiMo Tig

TYPE	Solid stainless steel wire for joining and cladding. (Type410NiMo, 1.4351)						
APPLICATIONS	CEWELD® 410NiMo Tig is used for welding similar martensitic and martensitic-ferritic steels in various applications such as water turbines, compressor construction, steam power plant construction, continuous casting rolls, centrifuges, valves, Pelton and Francis turbines.						
PROPERTIES	CEWELD® 410NiMo Tig has comparable properties to steels of the same or similar types. It is resistant to water and steam. The preheating and interpass temperature should be 100 - 160°C for thick-walled parts. The heat input should be max. 15 kJ/cm. Annealing at 580 - 620°C is possible.						
CLASSIFICATION	AWS	A 5.9: ER410NiMo					
	EN ISO	14343-A: W 13 4					
	W.Nr.	1.4313					
	F-nr	6					
	FM	5					
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	CE						
WELDING POSITIONS							
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	Cr	Ni	Mo	
	0.02	0.4	0.4	12	4.5	0.5	
MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardne
	As Welded	650	790	18	RT	-20°C	
	580°C±15°C 8h	780	860	18	50	38 HRc	
						40	250 H
REDRYING	Not required						
GAS ACC. EN ISO 14175	I1						



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410 NIMO TIG 1,6 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663411952
410 NIMO TIG 2,0 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663411969
410 NIMO TIG 2,4 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663411976
410 NIMO TIG 3,2 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663411983