



CEWELD 410 NiMo

TYPE	Solid stainless steel wire for joining and cladding.																												
APPLICATIONS	CEWELD® 410NiMo 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	<p>CEWELD 410NiMo has comparable properties to steels of the same or similar types. It is resistant to water and steam.</p> <p>The preheating and interpass temperature should be 100 - 160°C for thick-walled parts.</p> <p>The heat input should be max. 15 kJ/cm. Annealing at 580 - 620°C is possible.</p>																												
CLASSIFICATION	AWS	A 5.9: ER410NiMo																											
	EN ISO	14343-A: G 13 4																											
	W.Nr.	1.4351																											
	F-nr	6																											
	FM	5																											
SUITABLE FOR	<p>13%Cr - 4%Ni - 0,5%Mo Steel</p> <p>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</p>																												
APPROVALS	CE																												
WELDING POSITIONS																													
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>Cu</th> <th>Co</th> </tr> </thead> <tbody> <tr> <td>0.02</td> <td>0.4</td> <td>0.4</td> <td>12</td> <td>4.5</td> <td>0.5</td> <td>0.07</td> <td>0.1</td> </tr> </tbody> </table>							C	Si	Mn	Cr	Ni	Mo	Cu	Co	0.02	0.4	0.4	12	4.5	0.5	0.07	0.1						
C	Si	Mn	Cr	Ni	Mo	Cu	Co																						
0.02	0.4	0.4	12	4.5	0.5	0.07	0.1																						
MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R_{p0,2} (MPa)</th> <th rowspan="2">R_m (MPa)</th> <th rowspan="2">A₅ (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th>RT</th> <th>-20°C</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>650</td> <td>790</td> <td>15</td> <td>50</td> <td>38 HRc</td> <td rowspan="2">250 HB</td> </tr> <tr> <td>580°C±15°C 8h</td> <td>765</td> <td>840</td> <td>18</td> <td>50</td> <td>40</td> </tr> </tbody> </table>							Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness	RT	-20°C	As Welded	650	790	15	50	38 HRc	250 HB	580°C±15°C 8h	765	840	18	50	40
Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness																							
				RT	-20°C																								
As Welded	650	790	15	50	38 HRc	250 HB																							
580°C±15°C 8h	765	840	18	50	40																								
REDRYING	Not required																												
GAS ACC. EN ISO 14175	M12																												



CEWELD 410 NiMo

410 NIMO 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663411846

410 NIMO 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663411853

410 NIMO 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663411860