



CEWELD AA M410 NiMo

TYPE	Metal cored CrNiMo alloyed welding wire for rebuilding and cladding							
APPLICATIONS	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.							
PROPERTIES	Good corrosion and abrasion resistance as required by water turbines in hydropower plants.							
CLASSIFICATION	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						
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	S	Cr	Ni	Mo
	0.06	0.8	1	0.015	0.015	12.5	4.5	0.5
MECHANICAL PROPERTIES	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	
REDRYING	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