



CEWELD E 410 NiMo

TYPE Basic coated high performance electrode for surfacing and joint welding of ferritic-martensitic ferritic-martensitic chromium steels. (410NiMo, E 13 4)

APPLICATIONS CEWELD® E 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. For thicker materials (over 10 mm), preheating to a maximum of 150°C is recommended, followed by tempering or normalizing after welding. When welding joints, a bufferlayer with CEWELD® CroNi 29/9 S or CEWELD® 4370 Ti electrode is often advised.

PROPERTIES CEWELD® E 410NiMo 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 5.4: E 410NiMo
EN ISO	3581-A: E 13 4 B 42
W.Nr.	1.4351
F-nr	4
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	Cr	Ni	Mo
0.055	0.77	0.65	13	4.1	0.6

MECHANICAL PROPERTIES

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
605°C- 645°C 8h	600	800	25	310 HB

REDRYING 300°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD E 410 NiMo

E 410 NIMO 2,5 X 350MM

Packaging	KG/unit	EanCode
Can	2,5	8720663411549

E 410 NIMO 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2,5	8720663411556

E 410 NIMO 4,0 X 350MM

Packaging	KG/unit	EanCode
Can	2,5	8720663411563