



CEWELD 410 NiMo Tig

TYPE	Fil de Soudage 410 en acier inoxydable avec 13 % de chrome et 4% de Ni pour l'assemblage et revêtement type 410 NiMo																						
APPLICATIONS	Rouleaux de coulée continue, centrifugeuses, vannes, turbines Pelton et Francis																						
PROPRIÉTÉS	Fil de soudage du type 12% Cr, 4,5% Ni, 0,5% Mo. Le 410NiMo est utilisé pour souder des aciers martensitiques et martensitiques-ferritiques similaires dans différentes applications, telles que les turbines hydrauliques.																						
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.9: ER410NiMo</td> </tr> <tr> <td>EN ISO</td> <td>14343-A: W 13 4</td> </tr> <tr> <td>W.Nr.</td> <td>1.4351</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>5</td> </tr> </table>	AWS	A 5.9: ER410NiMo	EN ISO	14343-A: W 13 4	W.Nr.	1.4351	F-nr	6	FM	5												
AWS	A 5.9: ER410NiMo																						
EN ISO	14343-A: W 13 4																						
W.Nr.	1.4351																						
F-nr	6																						
FM	5																						
CONVIENT POUR	<p>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</p>																						
AGRÉMENTS	CE																						
POSITIONS DE SOUDAGE																							
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>Cr</th> <th>Ni</th> <th>Mo</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> </tr> </tbody> </table>	C	Si	Mn	Cr	Ni	Mo	0.02	0.4	0.4	12	4.5	0.5										
C	Si	Mn	Cr	Ni	Mo																		
0.02	0.4	0.4	12	4.5	0.5																		
PROPRIÉTÉS MÉCANIQUES	<table border="1"> <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>18</td> <td>50</td> <td>38 HRc</td> <td rowspan="2">250 HB</td> </tr> <tr> <td>580°C±15°C 8h</td> <td>780</td> <td>860</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	18	50	38 HRc	250 HB	580°C±15°C 8h	780	860	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	18	50	38 HRc	250 HB																	
580°C±15°C 8h	780	860	18	50	40																		
ETUVAGE	Not required																						
GAS ACC. EN ISO 14175	I1																						



CEWELD 410 NiMo Tig

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