



# CEWELD 410 NiMo Tig

TYPE	Solid stainless steel wire for joining and cladding.																								
TOEPASSINGEN	410NiMo Tig is used for welding similar martensitic and martensitic-ferritic steels in different applications, such as hydro turbines.																								
EIGENSCHAPPEN	Solid welding wire of the 12% Cr, 4.5% Ni, 0.5% Mo type.																								
CLASSIFICATIE	AWS	A 5.9: ER410NiMo																							
	EN ISO	14343-A: W 13 4																							
	W.Nr.	1.4351																							
	F-nr	6																							
	FM	5																							
GESCHIKT VOOR	<b>13%Cr - 4%Ni - 0,5%Mo Steel</b> 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																								
GOEDKEURINGEN	CE																								
LASPOSITIES																									
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											
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MECHANISCHE WAARDEN	<table border="1"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R<sub>P0,2</sub> (MPa)</th> <th rowspan="2">R<sub>m</sub> (MPa)</th> <th rowspan="2">A<sub>5</sub> (%)</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></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> <td>250 HB</td> </tr> </tbody> </table>		Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness	RT	-20°C	As Welded	650	790	18	50	38 HRc		580°C±15°C 8h	780	860	18	50	40	250 HB
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HERDROGEN	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