




CEWELD AA 410 NiMo

TYPE	Flux cored CrNiMo alloyed welding wire for rebuilding and cladding																
ANWENDUNGEN	Continuous casting rolls, centrifuges, valves, Pelton- and Francis- turbines																
EIGENSCHAFTEN	Hardfacing alloy for cladding steel mill rollers, thermoshock resistant and suitable for Francis and Pelton turbines. Used in steam power plants for its excellent resistance to cavitation and stress corrosion cracking. CEWELD® AA 410NiMo is a Cr-Ni-Mo- alloyed, gas-shielded flux-cored wire electrode for cladding. The corrosion resistant deposit offers a medium hardness and is resistant against metal-metal wear and high surface pressure.																
KLASSIFIKATION	AWS A 5.22: E410NiMoT0-4 EN ISO 14700: T Fe7, 17633-A: T 13 4 M M21 2 / T 410NiMo																
GEEIGNET FÜR	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																
ZULASSUNGEN																	
SCHWEISSPOSITIONEN																	
TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th style="width: 12.5%;">C</th> <th style="width: 12.5%;">Si</th> <th style="width: 12.5%;">Mn</th> <th style="width: 12.5%;">P</th> <th style="width: 12.5%;">Cr</th> <th style="width: 12.5%;">Ni</th> <th style="width: 12.5%;">Mo</th> <th style="width: 12.5%;">Fe</th> </tr> </thead> <tbody> <tr> <td>0.05</td> <td>0.9</td> <td>0.9</td> <td>0.015</td> <td>13.5</td> <td>4.5</td> <td>0.7</td> <td>Rem.</td> </tr> </tbody> </table>	C	Si	Mn	P	Cr	Ni	Mo	Fe	0.05	0.9	0.9	0.015	13.5	4.5	0.7	Rem.
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MECHANISCHE GÜTEWERTE	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th style="width: 33%;">Heat Treatment</th> <th style="width: 16.5%;">R_{p0,2} (MPa)</th> <th style="width: 16.5%;">R_m (MPa)</th> <th style="width: 16.5%;">A₅ (%)</th> <th style="width: 16.5%;">Hardness</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td></td> <td>>760</td> <td>>35</td> <td>40 HRc</td> </tr> </tbody> </table>	Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness	As Welded		>760	>35	40 HRc						
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As Welded		>760	>35	40 HRc													
RÜCKTROCKNUNG	Not required																
GAS ACC. EN ISO 14175	M21																



CEWELD AA 410 NiMo

AA 410 NIMO 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663411761

AA 410 NIMO 2,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663411815

AA 410 NIMO 2,4MM

Packaging	KG/unit	EanCode
BS-300	15	8720663411822