



CEWELD 410 NiMo

TYPE	Solid stainless steel wire for joining and cladding.							
APPLICATIONS	CEWELD® 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.							
PROPERTIES	CEWELD 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 5.9: ER410NiMo						
	EN ISO	14343-A: G 13 4						
	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	CE							
WELDING POSITIONS								
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	Cr	Ni	Mo	Cu	Co
	0.02	0.4	0.4	12	4.5	0.5	0.07	0.1
MECHANICAL PROPERTIES	Heat Treatment	RP0,2 (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness	
					RT	-20°C		
	As Welded	650	790	15	50	38 HRc		
	580°C±15°C 8h	765	840	18	50	40	250 HB	
REDRYING	Not required							
GAS ACC. EN ISO 14175	M12							



CEWELD 410 NiMo

410 NIMO 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663411846

410 NIMO 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663411853

410 NIMO 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663411860