



CEWELD AA M410 NiMo

TYPE Metal cored CrNiMo alloyed welding wire for rebuilding and cladding

APPLICATIONS AA M410NiMo is a Cr-Ni-Mo- alloyed, gas-shielded metal-cored wire electrode for cladding. The corrosion resistant deposit offers a medium hardness and is resistant against metal-metal wear and high surface pressure. He is used in steel mill rollers, thermoshock resistant and suitable for Francis and Pelton turbines. Used in steam power plants for its excelent resistance to cavitation and stress corrosion cracking.

PROPERTIES Good corrosion and abrasion resistance as required by water turbines in hydropower plants.

CLASSIFICATION

AWS	A 5.22: E410NiMoT0-4
EN ISO	17633-A: T 13 4 M M21 2 / T 410NiMo
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

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.06	0.8	1	0.015	0.015	12.5	4.5	0.5

MECHANICAL PROPERTIES

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V	Hardness
				0°C	
As Welded	800	890	19	67	40 HRc

REDRYING 140°C / 24 hr

GAS ACC. EN ISO 14175 M21



CEWELD AA M410 NiMo

AA M410 NIMO 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663411785