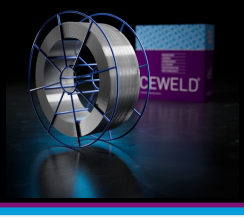


CEWELD 410 NiMo

certilas® THE FILLER METAL SPECIALIST

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

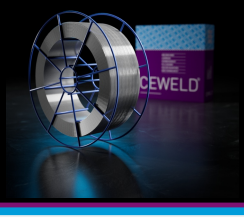
Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				RT	-20°C	
As Welded	650	790	15	50	38 HRc	
580°C±15°C 8h	765	840	18	50	40	250 HB

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