

# CEWELD AA M410 NiMo

**TYPE** Metal cored CrNiMo alloyed welding wire for rebuilding and cladding

**ANWENDUNGEN** 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.

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

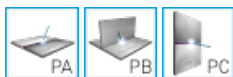
**KLASSIFIKATION**

|        |                                     |
|--------|-------------------------------------|
| 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                                   |

**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 (%)**

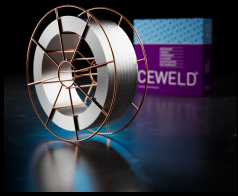
| C    | Si  | Mn | P     | S     | Cr   | Ni  | Mo  |
|------|-----|----|-------|-------|------|-----|-----|
| 0.06 | 0.8 | 1  | 0.015 | 0.015 | 12.5 | 4.5 | 0.5 |

**MECHANISCHE GÜTEWERTE**

| Heat<br>Treatment | R <sub>P0,2</sub><br>(MPa) | R <sub>m</sub><br>(MPa) | A <sub>5</sub><br>(%) | Impact Energy (J) ISO-V | Hardness |
|-------------------|----------------------------|-------------------------|-----------------------|-------------------------|----------|
|                   |                            |                         |                       | 0°C                     |          |
| As Welded         | 800                        | 890                     | 19                    | 67                      | 40 HRc   |

**RÜCKTROCKNUNG** 140°C / 24 hr

**GAS ACC. EN ISO 14175** M21



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AA M410 NIMO 1,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663411785 |