



CEWELD E 410 NiMo

TYPE	Basic coated high performance electrode for surfacing and joint welding of ferritic-martensitic ferritic-martensitic chromium steels. (410NiMo, E 13 4)					
APPLICATIONS	CEWELD® E 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. For thicker materials (over 10 mm), preheating to a maximum of 150°C is recommended, followed by tempering or normalizing after welding. When welding joints, a bufferlayer with CEWELD® CroNi 29/9 S or CEWELD® 4370 Ti electrode is often advised.					
PROPERTIES	CEWELD® E 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 5.4: E 410NiMo				
	EN ISO	3581-A: E 13 4 B 42				
	F-nr	4				
	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	 PA  PB  PC  PF					
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	Cr	Ni	Mo
	0.055	0.77	0.65	13	4.1	0.6
MECHANICAL PROPERTIES	Heat Treatment		R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Hardness
	605°C- 645°C 8h		600	800	25	310 HB
REDRYING	300°C / 2 hr					
GAS ACC. EN ISO 14175						



CEWELD E 410 NiMo

E 410 NIMO 2,5 X 350MM

Packaging	KG/unit	EanCode
Can	2,5	8720663411549

E 410 NIMO 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2,5	8720663411556

E 410 NIMO 4,0 X 350MM

Packaging	KG/unit	EanCode
Can	2,5	8720663411563