

# CEWELD AA 310 NiMo

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

**APPLICATIONS** CEWELD® AA 310 NiMo is mainly used for roll coatings against hot wear, preferably in steelworks. Continuous casting rolls, steam turbines, valve seats.

**PROPRIÉTÉS** CEWELD® AA 310 NiMo produces corrosion-resistant, medium-hardness 13 % Cr weld metal that does not fatigue, even at high temperatures.  
Heating the high-chromium martensitic alloy allows the hardness to be adjusted precisely within the range of 43–45 HRc.  
The interpass temperature should not exceed 450°C. The weld metal is tough and can be machined.

**CLASSIFICATION** EN ISO 14700: T Fe7

**CONVIENT POUR** **12%Cr - 2%Ni - 1,0%Mo Steel**  
For roll coatings against hot wear, preferably in steelworks. Continuous casting rolls

**AGRÉMENTS**

**POSITIONS DE SOUDAGE**



**ANALYSE CHIMIQUE  
TYPIQUE DU MÉTAL DE  
SOUDURE (%)**

| C    | Si  | Mn | Cr | Ni | Mo | Nb  | V   |
|------|-----|----|----|----|----|-----|-----|
| 0.12 | 0.5 | 1  | 12 | 2  | 1  | 0.2 | 0.2 |

**PROPRIÉTÉS MÉCANIQUES**

| Heat Treatment | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Hardness |
|----------------|-------------------------|----------------------|--------------------|----------|
| As Welded      |                         |                      |                    | 44 HRc   |

**ETUVAGE** Not required

**GAS ACC. EN ISO 14175** M21