



# 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.

**PROPRIÉTÉS** 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

**CONVIENT POUR** **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

**AGRÉMENTS**

**POSITIONS DE SOUDAGE**



**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

**PROPRIÉTÉS MÉCANIQUES**

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

**ETUVAGE** 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