CEWELD®

AA M410 NiMo

CATEGORY	FCAW Flux-Cored
TYPE	Metal cored CrNiMo alloyed welding wire for rebuilding and cladding
APPLICATIONS	Continuous casting rolls, centrifuges, valves, Pelton- and Francis- turbines
PROPERTIES	Good corrosion and abrasion resistance as required by water turbines in hydropower plants.
CLASSIFICATION	AWS A 5.22: EC 410NiMo EN ISO 17633-A: T13 4 MM3 DIN: W.Nr. 1.4313
SUITABLE FOR	Water and steam turbine parts of the same kind, thermoshock and high heat resistant. 1.4313, 1.4002, (G)X5CrNi(Mo) 13 4, X6CrAl 13, Grade CA 6 NM.
APPROVALS	CE approved
WELDING POSITIONS:	

FILLER METAL ANALYSIS % (TYPICAL VALUES)

C	Mn	Si	Cr	Ni	Mo	Fe
0.02	0.46	0.3	11.9	4.3	0.6	Rem

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (N/mm^2)	Rm (N/mm^2)	A5 (%)	Impact Energy (J) ISO-V 0°C	-40°C	-60°C	Hardness HRc
AW	805	890	19	67			38-42

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet
1,2	20-38	150-330	S-300	15	1080
1.6	24-42	200-380	S-300	15	1080

REDRYING TEMPERATURE	150°C/24hr
GAS ACC. EN ISO 14175:	M21