

E 410 NiMo

CATEGORY SMAW Stick Electrodes

TYPE Basic coated elektrode for joining and cladding.

APPLICATIONS Welding and overlay cladding from 13%Cr and 13%Cr(Ni) steels

CLASSIFICATION

AWS	A 5.4: E 410 NiMo-25
EN ISO	3581: E 13 4 B 130 36 X
DIN: W.Nr.	1.4351
DIN	8556: E 13 4 B25

SUITABLE FOR 1.4313, 1.4000, 1.4001, 1.4002, 1.4351, 1.4414, G-X5CrNi 13 4, X3CrNiMo 13 4, X3CrNiMo 13 4, grade CA 6 NM, X4CrNiMo 13 4, water turbines, valves, steam resistant.

WELDING POSITIONS:



C	Mn	Fe	Cr	Ni	Mo
< 0,1	< 0,7	Rest	13	4	0,75

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				-20°C	-40°C	-60°C	
AW	600	800	25				38 HRc

AW: As Welded

WELDING PARAMETERS PACKING

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A) DC+	kg / can	kg / 6pack	kg / 1000
2,5	350	60-90	2,5	15	
3,2	350	80-110	2,5	15	
4,0	350	100-150	2,5	15	

REDRYING TEMPERATURE 320°C / 2hr