

AA 410 NiMo

CATEGORY FCAW Flux-Cored

TYPE Fluxcored CrNiMo alloyed welding wire for rebuilding and cladding

APPLICATIONS Continuous casting rolls, centrifuges, valves, Pelton- and Francis- turbines

PROPERTIES Hardfacing alloy for cladding steel mill rollers, thermoshock resistant and suitable for Francis and Pelton turbines. Used in steam power plants for its excellent resistance to cavitation and stress corrosion cracking. AA 410NiMo is a Cr-Ni-Mo- alloyed, gas-shielded flux-cored wire electrode for cladding. The corrosion resistant deposit offers a medium hardness and is resistant against metal-metal wear and high surface pressure.

CLASSIFICATION

AWS	A 5.22: E 410NiMo
EN ISO	14700: ~410NiMo
DIN: W.Nr.	1.4351
DIN	8555: MF 5-40-CP

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.

WELDING POSITIONS:



C	Mn	Si	Cr	Ni	Mo	Fe
0.05	0.9	0.9	13.5	4.5	0.75	Rem

MECHANICAL PROPERTIES

Heat Treatment	Rp _{0,2} (N/mm ²)	Rm (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V			Hardness HRc
				-20°C	-40°C	-60°C	
AW							38-42

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet
1,2	18-26	120-220	S-300	15	1080
1.6	20-27	140-260	S-300	15	1080
2.0	22-28	140-320	H-415	25	900
2.4	24-29	160-380	H-415	25	900

REDRYING TEMPERATURE 150°C/24hr

GAS ACC. EN ISO 14175: M21