



CEWELD 410 NiMo Tig

| TYPE | Solid stainless steel wire for joining and cladding. | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|---|----------------------|--------------------|-------------------------|--------|----------|----------------|-------------------------|----------------------|--------------------|-------------------------|------|----------|-----|-------|-----------|-----|-----|----|----|--------|--|---------------|-----|-----|----|----|----|--------|
| APPLICATIONS | 410NiMo Tig is used for welding similar martensitic and martensitic-ferritic steels in different applications, such as hydro turbines. | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| PROPERTIES | Solid welding wire of the 12% Cr, 4.5% Ni, 0.5% Mo type. | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| CLASSIFICATION | AWS | A 5.9: ER410NiMo | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | EN ISO | 14343-A: W 13 4 | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | W.Nr. | 1.4351 | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | F-nr | 6 | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | FM | 5 | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| SUITABLE FOR | 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 | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| APPROVALS | CE | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| WELDING POSITIONS | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | <table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th style="width: 16.6%;">C</th> <th style="width: 16.6%;">Si</th> <th style="width: 16.6%;">Mn</th> <th style="width: 16.6%;">Cr</th> <th style="width: 16.6%;">Ni</th> <th style="width: 16.6%;">Mo</th> </tr> </thead> <tbody> <tr> <td>0.02</td> <td>0.4</td> <td>0.4</td> <td>12</td> <td>4.5</td> <td>0.5</td> </tr> </tbody> </table> | | | | | C | Si | Mn | Cr | Ni | Mo | 0.02 | 0.4 | 0.4 | 12 | 4.5 | 0.5 | | | | | | | | | | | | |
| C | Si | Mn | Cr | Ni | Mo | | | | | | | | | | | | | | | | | | | | | | | | |
| 0.02 | 0.4 | 0.4 | 12 | 4.5 | 0.5 | | | | | | | | | | | | | | | | | | | | | | | | |
| MECHANICAL PROPERTIES | <table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R_{P0,2} (MPa)</th> <th rowspan="2">R_m (MPa)</th> <th rowspan="2">A₅ (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th>RT</th> <th>-20°C</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>650</td> <td>790</td> <td>18</td> <td>50</td> <td>38 HRc</td> <td></td> </tr> <tr> <td>580°C±15°C 8h</td> <td>780</td> <td>860</td> <td>18</td> <td>50</td> <td>40</td> <td>250 HB</td> </tr> </tbody> </table> | | | | | | Heat Treatment | R _{P0,2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | Hardness | RT | -20°C | As Welded | 650 | 790 | 18 | 50 | 38 HRc | | 580°C±15°C 8h | 780 | 860 | 18 | 50 | 40 | 250 HB |
| Heat Treatment | R _{P0,2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | Hardness | | | | | | | | | | | | | | | | | | | | | | | |
| | | | | RT | -20°C | | | | | | | | | | | | | | | | | | | | | | | | |
| As Welded | 650 | 790 | 18 | 50 | 38 HRc | | | | | | | | | | | | | | | | | | | | | | | | |
| 580°C±15°C 8h | 780 | 860 | 18 | 50 | 40 | 250 HB | | | | | | | | | | | | | | | | | | | | | | | |
| REDRYING | Not required | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| GAS ACC. EN ISO 14175 | I1 | | | | | | | | | | | | | | | | | | | | | | | | | | | | |



CEWELD 410 NiMo Tig

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|---------------------------|-----------|---------|---------------|
| 410 NIMO TIG 1,6 X 1000MM | Packaging | KG/unit | EanCode |
| | Tube | 5 | 8720663411952 |
| 410 NIMO TIG 2,0 X 1000MM | Packaging | KG/unit | EanCode |
| | Tube | 5 | 8720663411969 |
| 410 NIMO TIG 2,4 X 1000MM | Packaging | KG/unit | EanCode |
| | Tube | 5 | 8720663411976 |
| 410 NIMO TIG 3,2 X 1000MM | Packaging | KG/unit | EanCode |
| | Tube | 5 | 8720663411983 |