



# CEWELD 410 NiMo

| TYPE  | Massief roestvrij staaldraad voor verbinden en cladden.   |                |                         |                      |                    |                         |                    |          |                         |       |           |     |     |     |     |        |        |               |     |     |    |    |    |
|---|---|----------------|-------------------------|----------------------|--------------------|-------------------------|--------------------|----------|-------------------------|-------|-----------|-----|-----|-----|-----|--------|--------|---------------|-----|-----|----|----|----|
| TOEPASSINGEN                                      | CEWELD® 410NiMo wordt gebruikt voor het lassen van vergelijkbare martensitische en martensitisch-ferritische staalsoorten in diverse toepassingen zoals waterturbines, compressorbouw, stoomkrachtcentrales, continugietwalsen, centrifuges, kleppen, Pelton- en Francis-turbines.  |                |                         |                      |                    |                         |                    |          |                         |       |           |     |     |     |     |        |        |               |     |     |    |    |    |
| EIGENSCHAPPEN                                     | CEWELD 410NiMo heeft vergelijkbare eigenschappen als staal van dezelfde of vergelijkbare types. Het is bestand tegen water en stoom.<br>De voorverwarmings- en interpasstemperatuur moet 100 - 160 °C zijn voor dikwandige onderdelen. De warmte-inbreng moet max. 15 kJ/cm zijn. Uitgloeien bij 580 - 620 °C is mogelijk.  |                |                         |                      |                    |                         |                    |          |                         |       |           |     |     |     |     |        |        |               |     |     |    |    |    |
| CLASSIFICATIE                                     | AWS A 5.9: ER410NiMo<br>EN ISO 14343-A: G 13 4<br>W.Nr. 1.4351<br>F-nr 6<br>FM 5  |                |                         |                      |                    |                         |                    |          |                         |       |           |     |     |     |     |        |        |               |     |     |    |    |    |
| GESCHIKT VOOR                                     | <b>13%Cr - 4%Ni - 0,5%Mo Steel</b><br>1.4000, 1.4001, 1.4002, 1.4313, 1.4317, 1.4407, 1.4413, 1.4414,<br>GX4CrNi13-4, X3CrNiMo13-4, GX5CrNiMo13-4, GX4CrNiMo13-4, X 6 Cr 13, X 7 Cr 14, X 6 CrAl 13<br>ACI Gr. CA 6 NM  |                |                         |                      |                    |                         |                    |          |                         |       |           |     |     |     |     |        |        |               |     |     |    |    |    |
| GOEDKEURINGEN                                     | CE  |                |                         |                      |                    |                         |                    |          |                         |       |           |     |     |     |     |        |        |               |     |     |    |    |    |
| LASPOSITIES                                       |   |                |                         |                      |                    |                         |                    |          |                         |       |           |     |     |     |     |        |        |               |     |     |    |    |    |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | <table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>Cu</th> <th>Co</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> <td>0.07</td> <td>0.1</td> </tr> </tbody> </table>   | C              | Si                      | Mn                   | Cr                 | Ni                      | Mo                 | Cu       | Co                      | 0.02  | 0.4       | 0.4 | 12  | 4.5 | 0.5 | 0.07   | 0.1    |               |     |     |    |    |    |
| C   | Si  | Mn             | Cr                      | Ni                   | Mo                 | Cu                      | Co                 |          |                         |       |           |     |     |     |     |        |        |               |     |     |    |    |    |
| 0.02  | 0.4   | 0.4            | 12                      | 4.5                  | 0.5                | 0.07                    | 0.1                |          |                         |       |           |     |     |     |     |        |        |               |     |     |    |    |    |
| MECHANISCHE WAARDEN                               | <table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R<sub>P0,2</sub> (MPa)</th> <th rowspan="2">R<sub>m</sub> (MPa)</th> <th rowspan="2">A<sub>5</sub> (%)</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>15</td> <td>50</td> <td>38 HRc</td> <td rowspan="2">250 HB</td> </tr> <tr> <td>580°C±15°C 8h</td> <td>765</td> <td>840</td> <td>18</td> <td>50</td> <td>40</td> </tr> </tbody> </table> | Heat Treatment | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |                    | Hardness | RT                      | -20°C | As Welded | 650 | 790 | 15  | 50  | 38 HRc | 250 HB | 580°C±15°C 8h | 765 | 840 | 18 | 50 | 40 |
| Heat Treatment                                    | R <sub>P0,2</sub> (MPa)   |                |                         |                      |                    | R <sub>m</sub> (MPa)    | A <sub>5</sub> (%) |          | Impact Energy (J) ISO-V |       | Hardness  |     |     |     |     |        |        |               |     |     |    |    |    |
|   |   | RT             | -20°C                   |                      |                    |                         |                    |          |                         |       |           |     |     |     |     |        |        |               |     |     |    |    |    |
| As Welded   | 650   | 790            | 15                      | 50                   | 38 HRc             | 250 HB                  |                    |          |                         |       |           |     |     |     |     |        |        |               |     |     |    |    |    |
| 580°C±15°C 8h                                     | 765   | 840            | 18                      | 50                   | 40                 |                         |                    |          |                         |       |           |     |     |     |     |        |        |               |     |     |    |    |    |
| HERDROGEN   | Not required  |                |                         |                      |                    |                         |                    |          |                         |       |           |     |     |     |     |        |        |               |     |     |    |    |    |
| GAS ACC. EN ISO 14175                             | M12   |                |                         |                      |                    |                         |                    |          |                         |       |           |     |     |     |     |        |        |               |     |     |    |    |    |



# CEWELD 410 NiMo

410 NIMO 1,0MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663411846 |

410 NIMO 1,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663411853 |

410 NIMO 1,6MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663411860 |