

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.
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APPROVALS	CE approved
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WELDING POSITIONS:	
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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)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc
				0°C	-40°C	-60°C	
AW	805	890	19	67			38-42

WELDING PARAMETERS / PACKING					
D (mm)	Welding Parameters		spool type	Packing	
	Voltage (V)	Current (A)		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
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GAS ACC. EN ISO 14175:	M21
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