

CEWELD AA 310 NiMo

TYPE Flux cored CrNiMo alloyed welding wire for rebuilding and cladding

APPLICATIONS CEWELD® AA 310 NiMo is mainly used for roll coatings against hot wear, preferably in steelworks. Continuous casting rolls, steam turbines, valve seats.

PROPRIÉTÉS CEWELD® AA 310 NiMo produces corrosion-resistant, medium-hardness 13 % Cr weld metal that does not fatigue, even at high temperatures.
Heating the high-chromium martensitic alloy allows the hardness to be adjusted precisely within the range of 43–45 HRc.
The interpass temperature should not exceed 450°C. The weld metal is tough and can be machined.

CLASSIFICATION EN ISO 14700: T Fe7

CONVIENT POUR **12%Cr - 2%Ni - 1,0%Mo Steel**
For roll coatings against hot wear, preferably in steelworks. Continuous casting rolls

AGRÉMENTS

POSITIONS DE SOUDAGE



**ANALYSE CHIMIQUE
TYPIQUE DU MÉTAL DE
SOUDURE (%)**

C	Si	Mn	Cr	Ni	Mo	Nb	V
0.12	0.5	1	12	2	1	0.2	0.2

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Hardness
As Welded				44 HRc

ETUVAGE Not required

GAS ACC. EN ISO 14175 M21