



CEWELD SACW MnCr

TYPE	Flux-cored wire for submerged-arc welding.							
ANWENDUNGEN	Building up worn out parts that suffer from wear combined with high impact, buffer layers etc.							
EIGENSCHAFTEN	Austenitic deposit with strain hardening properties and no limits in the number of layers. The deposit is non magnetic and can not be flame cut. Extreme resistance to heavy impact loads. The weld deposit offers fair corrosion resistance and has strain hardening properties. This alloy should be applied at highest impact and pressure loads applications. Best to be used with welding flux FL 915							
KLASSIFIKATION	EN ISO		14700: T Fe9					
GEEIGNET FÜR	Rebuilding rails, crossings, crushing hammers, dredger teeth, rollers, blast furnace, mantles, Hardfacing manganese hard stee, buffer layers etc..							
ZULASSUNGEN								
SCHWEISSPOSITIONEN	  							
TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%)	C	Si	Mn	Cr	Ni	Mo	V	Fe
	0.5	0.9	16	15	1.2	1.5	0.2	Rem.
MECHANISCHE GÜTEWERTE	Heat Treatment		R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Hardness		
	As Welded					240 HB		
	As Welded					500 HB		
RÜCKTROCKNUNG	140°C / 24 hr							
GAS ACC. EN ISO 14175								