



CEWELD E DUR 49

TYPE	Rutile Fe, Cr, Co and Mo based elektrode						
APPLICATIONS	Hardfacing of forging presses, hot piercing dies, stretching rolls, pinch rolls, hot strip mill table rolls and back-up rolls						
PROPRIÉTÉS	Rutile Fe, Cr, Co and Mo based elektotrode with high hot wear resistance, tensile strenght and a high resistance against sliding wear of metallic objects.It has a good retention of hardness up to 650°C and is non scaling up to 900° C thermo shock resistant and resistant to sudden changes of temperature.Work hardening. Not crack sensible.The number of layers can be done as necessary. The deposit can beadditionally treated with cutting tools.						
CLASSIFICATION	EN ISO		14700: E Fe3				
CONVIENT POUR	1.2311 40CrMnMo 7 1.2343 X38CrMoV 5 1 1.2344 X40CrMoV 5 1 1.2365 X32CrMoV 3 3 1.2367 X38CrMoV 5 3 1.2606 X37CrMoW 5 1 1.2713 55NiCrMoV 6 1.2714 56NiCrMoV 7						
AGRÉMENTS							
POSITIONS DE SOUDAGE	PAPBPCPF						
ANALYSE CHIMIQUE TYPIQUE DU MÉTAL DE SOUDURE (%)	C	Si	Mn	Cr	Mo	Fe	Co
	0.15	0.6	0.6	14	2.3	Rem.	13
PROPRIÉTÉS MÉCANIQUES	Heat Treatment		R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Hardness	
	As Welded					48 HRc	
ETUVAGE	300°C / 2 hr						
GAS ACC. EN ISO 14175							



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E DUR 49 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	3	8720663402141