



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 steel, 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)	A ₅ (%)	Hardness
As Welded				240 HB
As Welded				500 HB

RÜCKTROCKNUNG 140°C / 24 hr

GAS ACC. EN ISO 14175