



CEWELD OA Mn14

TYPE Self-shielded and slag forming flux-cored wire for gas-shielded welding

APPLICATIONS Welding parts of manganese steel that are exposed to impact and shock-like wear

PROPERTIES 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.
Hardness HB: After workhardening: 450HB

CLASSIFICATION EN ISO 14700: T Fe9
DIN 8555: MF 7-GF-250-KNP

SUITABLE FOR Rebuilding, buffer layers before hardfacing on steels with high carbon content, heavy impact loads, manganese steels

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Ni	Fe
1	0.4	13.5	4.5	0.5	Rem.

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded				230 HB

REDRYING 140°C / 24 hr

HARDNESS HB After hardening: 450HB

GAS ACC. EN ISO 14175



CEWELD OA Mn14

OA MN14 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663402981

OA MN14 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663403018

OA MN14 2,8MM

Packaging	KG/unit	EanCode
BS-300	15	8720663403025