



CEWELD OA MnCr

TYPE Tubular wire weldable without protective gas for rebuilding and buffer layers before hardfacing with extreme resistance to heavy impact loads.

APPLICATIONS Rebuilding heavy steel parts, buffer layers, rails, rails crossings, dredger teeth, blast furnace mantles etc..

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.

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

SUITABLE FOR Rebuilding, buffer layers, rails, rails crossings, dredger teeth, blast furnace mantles

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Ni	Mo	V	Fe
0.45	0.4	15.7	14.8	1.25	0.55	0.25	Rem.

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded				240 HB

REDRYING 140°C / 24 hr

HARDNESS HB after hardening: 500HB

GAS ACC. EN ISO 14175



CEWELD OA MnCr

OA MNCR 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663402967

OA MNCR 2,8MM

Packaging	KG/unit	EanCode
BS-300	15	8720663402974