



CEWELD AA SS 50

TYPE C, Cr, V-, W alloyed cored wire for hardfacing applications. (1.2564)

APPLICATIONS Rebuilding wornout parts that faces wear and impact combined with increased working temperatures. Hot dies, dies, punches, hammer dies, drawing rings Forging dies, mandrels slab shears, hot cuts, etc.

PROPERTIES Machinable ,Heat resistant weld deposit with excelent wear resistance. The weld deposit can be heat treated to offer maximum service protection. Tempered 560° C ~ 52 HRc Tempered 450° C ~ 49 HRc Tempered 350° C ~ 48 HRc Soft annealed 250 HB

CLASSIFICATION

EN ISO	14700: T Fe3
DIN	MSG 3–GF-45-T
W.Nr.	1.2567

SUITABLE FOR **45-52 HRc**
 1.2567, 1.2365, 1.2713, 1.2714, 1.2581
 30WCrV17 2, 32CrMoV12-283, 55NiCrMoV6, 55NiCrMoV7, X30WCrV9-3

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	V	W	Fe
0.3	0.75	0.8	2.5	0.6	4.5	Rem.

MECHANICAL PROPERTIES

Heat Treatment	RP0,2 (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded				47 HRc
580°C±15°C 1h				53 HRc

REDRYING 140°C / 2 hr

Hardening : 1060° C-1120° C°, hot bath, compressed air. Tempering : approx. 3 h / temperature depending on desired working hardness. Soft annealing : 2 - 4 h at 800° C -840° C / furnace cooling

GAS ACC. EN ISO 14175 M13