



CEWELD AA SS 50

TYPE	Tungsten alloyed cored wire for hardfacing applications..		
ANWENDUNGEN	Rebuilding wornout parts that faces wear and impact combined with increased working temperatures.		
EIGENSCHAFTEN	Machinable ,Heat resistant weld deposit with excelent wear resistance. The weld deposit can be heat treated to offer maximum service protection.		
KLASSIFIKATION	EN ISO DIN W.Nr.	14700: T Fe3 MSG 3–GF-45-T 1.2567	

GEEIGNET FÜR	45-52 HRc 1.2567, 1.2365, 1.2713, 1.2714, 1.2581 30WCrV17 2, 32CrMoV12-283, 55NiCrMoV6, 55NiCrMoV7, X30WCrV9-3
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ZULASSUNGEN

SCHWEISSPOSITIONEN



TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%)

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

MECHANISCHE GÜTEWERTE

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Hardness
As Welded				47 HRc
580°C±15°C 1h				53 HRc

RÜCKTROCKNUNG	140°C / 2 hr
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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
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