



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	 PA  PB  PC					
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)	A5 (%)	Hardness
	As Welded					230 HB
REDRYING	140°C / 24 hr					
HARDNESS HB	After hardening: 450HB					
GAS ACC. EN ISO 14175						



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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