



# 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 | <b>45-52 HRc</b><br>1.2567, 1.2365, 1.2713, 1.2714, 1.2581<br>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 | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | 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

|                       |     |
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| GAS ACC. EN ISO 14175 | M13 |
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