



CEWELD E DUR Mn14

TYPE	Strain hardening Basic coated electrode with high impact resistance.				
APPLICATIONS	CEWELD® E DUR Mn14 is suitable for build-up welding of worn workpieces made of high-manganese steels and parts that are predominantly exposed to impact and shock wear, such as: Excavator teeth and cutting edges, blow bars, excavator bolts, crusher jaws and cones, frogs and cross pieces.				
PROPERTIES	CEWELD® E DUR Mn14 has no limit to the number of layers that can be deposited in the event of rebuilding, but the heat input should be kept low (as with Mn steel). The weld metal offers work hardening properties from 250 to 450 HB. Recovery of: 140 %				
CLASSIFICATION	AWS EN ISO DIN F-nr	A 5.13: E FeMn-A 14700: E Fe9 8555: E 7-UM-250-K 71			
SUITABLE FOR	austenitic manganese steel, high impact loads, hammers, crushers, rebuilding, hardfacing, rails, crossings, Breaker teeth, etc..				
APPROVALS					
WELDING POSITIONS	 PA  PB  PC				
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	Ni	Fe
	0.8	0.4	13.5	3	Rem.
MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Hardness
	As Welded				260 HB
REDRYING	300°C / 2 hr				
GAS ACC. EN ISO 14175					



CEWELD E DUR Mn14

E DUR MN14 2,5 X 350MM

Packaging	KG/unit	EanCode
Can	2,5	8720663401953

E DUR MN14 3,2 X 450MM

Packaging	KG/unit	EanCode
Can	2,5	8720663401960

E DUR MN14 4,0 X 450MM

Packaging	KG/unit	EanCode
Can	2	8720663401977