



CEWELD SACW MnCr

TYPE	Flux-cored wire for submerged-arc welding.
TOEPASSINGEN	Building up worn out parts that suffer from wear combined with high impact, buffer layers etc.
EIGENSCHAPPEN	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. Extreme resistance to heavy impact loads. The weld deposit offers fair corrosion resistance and has strain hardening properties. This alloy should be applied at highest impact and pressure loads applications. Best to be used with welding flux FL 915
CLASSIFICATIE	EN ISO 14700: T Fe9
GESCHIKT VOOR	Rebuilding rails, crossings, crushing hammers, dredger teeth, rollers, blast furnace, mantles, Hardfacing manganese hard steel, buffer layers etc..

GOEDKEURINGEN

LASPOSITIES



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Ni	Mo	V	Fe
0.5	0.9	16	15	1.2	1.5	0.2	Rem.

MECHANISCHE WAARDEN

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded				240 HB
As Welded				500 HB

HERDROGEN 140°C / 24 hr

GAS ACC. EN ISO 14175