

CEWELD SS 6356

TYPE	Cobalt alloyed age hardenable hardfacing alloy for MIG welding.																										
APPLICATIONS	<p>CEWELD® SS 6356 is a hardenable, high-alloy material suitable for highly wear-resistant cladding in conditions involving abrasion and high working temperatures.</p> <p>Its main application is to create highly wear-resistant clad layers on cold and hot working tools. It is used for the repair and preventive maintenance of highly stressed cold and hot working tools, such as punching dies, cold and hot cutting knives, aluminium die cast moulds, cold forging dies, and drawing, stamping and chamfering tools.</p>																										
PROPERTIES	CEWELD® SS 6356 can be machined in the welded condition, and subsequent artificial aging optimizes resistance to hot wear and temperature changes.																										
CLASSIFICATION	EN ISO 14700: S Fe5 W.Nr. ~1.6356																										
SUITABLE FOR	All hot- and cold-work steels. GG and GGG cast iron materials. Similar materials: 1.2706 / 1.2709 / Böhler W720/21/22 / 1.6354 / 1.6358 (AMS 6512-6514) / Thyrodur / Corrax.																										
APPROVALS																											
WELDING POSITIONS	 PA  PB  PC  PD  PE  PF																										
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1"> <thead> <tr> <th>C</th><th>Si</th><th>Mn</th><th>Cr</th><th>Ni</th><th>Mo</th><th>Ti</th><th>Fe</th><th>Co</th></tr> </thead> <tbody> <tr> <td>0.01</td><td>0.4</td><td>0.03</td><td>0.2</td><td>18</td><td>4</td><td>1.6</td><td>Rem.</td><td>12</td></tr> </tbody> </table>									C	Si	Mn	Cr	Ni	Mo	Ti	Fe	Co	0.01	0.4	0.03	0.2	18	4	1.6	Rem.	12
C	Si	Mn	Cr	Ni	Mo	Ti	Fe	Co																			
0.01	0.4	0.03	0.2	18	4	1.6	Rem.	12																			
MECHANICAL PROPERTIES	<table border="1"> <thead> <tr> <th>Heat Treatment</th><th>$R_{P0,2}$ (MPa)</th><th>Rm (MPa)</th><th>A5 (%)</th><th>Hardness</th></tr> </thead> <tbody> <tr> <td>As Welded</td><td>880</td><td>980</td><td></td><td>38 HRc</td></tr> </tbody> </table>									Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness	As Welded	880	980		38 HRc								
Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness																							
As Welded	880	980		38 HRc																							
REDRYING	Not required																										
GAS ACC. EN ISO 14175	I1, M12, M13																										