

# CEWELD SS 6356

**TYPE** Cobalt alloyed age hardenable hardfacing alloy for MIG welding.

**APPLICATIONS** CEWELD® SS 6356 is a hardenable, high-alloy material suitable for highly wear-resistant cladding in conditions involving abrasion and high working temperatures. 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.

**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**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

| 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**

| Heat Treatment | R <sub>p0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Hardness |
|----------------|-------------------------|----------------------|--------------------|----------|
| As Welded      | 880                     | 980                  |                    | 38 HRc   |

**REDRYING** Not required

**GAS ACC. EN ISO 14175** I1, M12, M13