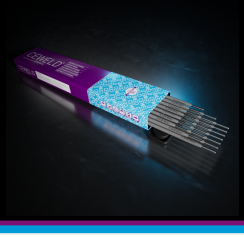


# CEWELD E DUR MnCr

certilas® THE FILLER METAL SPECIALIST

TYPE

Basic-coated strain hardening high recovery stick electrode for hardfacing.( Fe 9 )

APPLICATIONS

CEWELD® E DUR MnCr is a basic electrode for rebuilding and joining cold straining Mn steels or rebuilding parts that are subject to high impact and rolling wear.
Such as: Excavator teeth, beating arm, dredger bolts, crusher jaws and cones, sand blasting and shot peening devices;
Railway systems: crossing frogs and four-way pieces.

PROPERTIES

CEWELD® E DUR MnCr has no limit to the number of layers that can be applied in the event of rebuilding, but the heat input should be kept low (as with Mn steel, the interpass temperature should be < 250 °C).
Hardness: 250 [HB] up to 450 [HB] workhardened
Recovery: 140%

CLASSIFICATION

| | |
|---|---|
| AWS | A 5.13: E FeMnCr |
| EN ISO | 14700: E Fe9 |
| DIN | 8555: E 7-UM-250-K |
| F-nr | 71 |

SUITABLE FOR

Rebuilding and joining cold straining Mn steels or rebuilding parts that are subject to high impact and rolling wear. Breaker teeth, Crushers, Hammers, Crossings, Rails.

APPROVALS

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

| C | Mn | Cr | Fe | Si |
|---|---|---|---|---|
| 0.75 | 17.5 | 14 | Rem. | 0.4 |

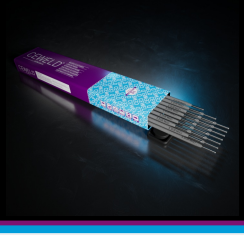
MECHANICAL PROPERTIES

| Heat Treatment | $R_{P0,2}$ (MPa) | Rm (MPa) | A5 (%) | Hardness |
|---|---|---|---|---|
| As Welded | | | | 270 HB |

REDRYING

300°C / 2 hr

GAS ACC. EN ISO 14175





# CEWELD E DUR MnCr

E DUR MNCR 2,5 X 350MM

| Packaging | KG/unit | EanCode |
|---|---|---|
| Can | 2,5 | 8720663401496 |

E DUR MNCR 3,2 X 350MM

| Packaging | KG/unit | EanCode |
|---|---|---|
| Can | 2,5 | 8720663401502 |

E DUR MNCR 4,0 X 450MM

| Packaging | KG/unit | EanCode |
|---|---|---|
| Can | 3,0 | 8720663401519 |