CEWELD SACW MnCr

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TYPE

Flux-cored wire for submerged-arc welding.

APPLICATIONS

Building up worn out parts that suffer from wear combined with high impact, buffer layers etc.

PROPRIÉTÉS

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

CLASSIFICATION

EN ISO 14700: T Fe9

CONVIENT POUR

Rebuilding rails, crossings, crushing hammers, dredger teeth, rollers, blast furnace, mantles, Hardfacing manganese hard stee, buffer layers etc..

AGRÉMENTS

POSITIONS DE SOUDAGE

ANALYSE CHIMIQUE TYPIQUE DU MÉTAL DE SOUDURE (%)

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

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded				240 HB
As Welded				500 HB

ETUVAGE

140°C / 24 hr

GAS ACC. EN ISO 14175