



CEWELD AA B57-62

TYPE	Seamless medium alloyed basic fluxcored wire with slag for hardfacing using Ar-CO2 mix												
APPLICATIONS	Rebuilding and cladding parts against strong abrasion and heavy impact.												
PROPERTIES	Due to the high resistance to cracking and toughness, all weld metal requires no buffer layer except on materials considered critical. In this situation CEWELD® ER 100 S-G is recommended. Suited for wear parts subject to heavy impact and shock. The interpass temperature should be maximum 250°C. The weld metal is machinable by special carbide tools, hardening is possible. The maximum hardness is dependent on the base metal and is achieved in the first layer. For material considered critical to cracking we advise to buffer with one layer CEWELD® AA B460.												
CLASSIFICATION	EN ISO 14700: T Fe4												
SUITABLE FOR	55-62 HRc hardfacing alloy against heavy impact and shock, bucket, loaders, crusher jaws, crusher cones, pumps, sand, snow scratchers, stone cutting tools etc.												
APPROVALS	No Approvals Found												
WELDING POSITIONS													
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td style="width: 20%;">C</td> <td style="width: 20%;">Si</td> <td style="width: 20%;">Mn</td> <td style="width: 20%;">Cr</td> <td style="width: 20%;">Mo</td> </tr> <tr> <td>0.5</td> <td>0.6</td> <td>1.5</td> <td>6</td> <td>0.5</td> </tr> </table>	C	Si	Mn	Cr	Mo	0.5	0.6	1.5	6	0.5		
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ALL WELD MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td style="width: 25%;">Heat Treatment</td> <td style="width: 10%;">R_{p0,2} MPa</td> <td style="width: 10%;">R_m MPa</td> <td style="width: 10%;">A₅ (%)</td> <td style="width: 10%;"></td> <td style="width: 35%;">Hardness Rockwell C</td> </tr> <tr> <td>As Welded /</td> <td></td> <td></td> <td></td> <td></td> <td>Avg. 60</td> </tr> </table>	Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)		Hardness Rockwell C	As Welded /					Avg. 60
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As Welded /					Avg. 60								
REDRYING TEMPERATURE	Not required												
GAS ACCORDING EN 14175	M21												