






CEWELD SACW MnCr

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.							
PROPERTIES	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					
SUITABLE FOR	Rebuilding rails, crossings, crushing hammers, dredger teeth, rollers, blast furnace, mantles, Hardfacing manganese hard steel, buffer layers etc..							
APPROVALS	No Approvals Found							
WELDING POSITIONS	<div>  </div>							
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	Cr	Ni	Mo	V	Fe
	0.5	0.9	16	15	1.2	1.5	0.2	Rem.
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} MPa	R _m MPa	A5 (%)	Hardness Brinell Hardness			
	As Welded /				Avg. 240			
	As Welded /1h				Avg. 500			
REDRYING TEMPERATURE	140°C / 24 hr							
GAS ACCORDING EN 14175								