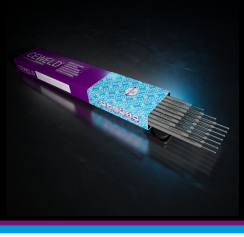


CEWELD E DUR MnCr

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

No Approvals Found

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Mn	Cr	Fe	Si
0.75	17.5	14	Rem.	0.4

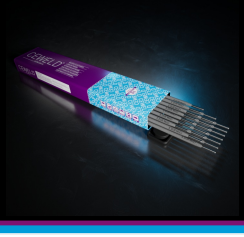
ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Hardness Brinell Hardness
As Welded /				Avg. 270

REDRYING TEMPERATURE

300°C / 2 hr

GAS ACCORDING EN 14175



CEWELD E DUR MnCr

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E DUR MNCR 2,5 X 350MM	Type	KG/unit	EANCode
	Can	2,5	8720663401496

E DUR MNCR 3,2 X 350MM	Type	KG/unit	EANCode
	Can	2,5	8720663401502

E DUR MNCR 4,0 X 450MM	Type	KG/unit	EANCode
	Can	3,0	8720663401519