




# CEWELD AA GGG

TYPE	Medium-alloy high-basicity flux-cored wire with slag for hardfacing using Ar-CO2 mix														
APPLICATIONS	Build-up of cast iron and alloyed grey-cast iron Well suited for warm and in special applications for cold welding. Used to fill-in voids and pores, build-up of worn-down parts. Build-up of cast iron and alloyed grey-cast iron Well suited for warm and in special applications for cold welding. Used to fill-in voids and pores, build-up of worn-down parts														
PROPERTIES	Very good welding and wetting characteristics and high resistance to cracks and fissures. Extreme good deposition rate compare to MMA.High strength and good bonding weld metal..														
CLASSIFICATION	EN ISO 1071: T C Fe-2														
SUITABLE FOR	DIN GG15 – GG40, GGG40 - GGG70, GTS35 - GTS 65 ASTM: A48 Class 25 B - A48 Class 60 B, A536 Grad 60-80 FGL 150- FGL 400, FGS 400 12 - FGS 600 3, MN350 10 - MN650 3														
APPROVALS	No Approvals Found														
WELDING POSITIONS															
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>Mo</th> <th>Fe</th> <th>Cr</th> <th>V</th> </tr> </thead> <tbody> <tr> <td>0.06</td> <td>0.4</td> <td>0.6</td> <td>0.1</td> <td>Rem.</td> <td>0.6</td> <td>6</td> </tr> </tbody> </table>	C	Si	Mn	Mo	Fe	Cr	V	0.06	0.4	0.6	0.1	Rem.	0.6	6
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ALL WELD MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th>Heat Treatment</th> <th>R<sub>p0,2</sub> MPa</th> <th>R<sub>m</sub> MPa</th> <th>A<sub>5</sub> (%)</th> <th>Hardness Brinell</th> </tr> </thead> <tbody> <tr> <td>As Welded /</td> <td></td> <td></td> <td></td> <td>Avg. 200</td> </tr> </tbody> </table>	Heat Treatment	R <sub>p0,2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)	Hardness Brinell	As Welded /				Avg. 200				
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REDRYING TEMPERATURE	Not required														
GAS ACCORDING EN 14175	M21														