



# CEWELD OA Mn14

<b>TYPE</b>	Self-shielded and slag forming flux-cored wire for gas-shielded welding
<b>APPLICATIONS</b>	Welding parts of manganese steel that are exposed to impact and shock-like wear
<b>PROPERTIES</b>	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. Hardness HB: After workhardening: 450HB
<b>CLASSIFICATION</b>	EN ISO                    14700: T Fe9 DIN                        8555: MF 7-GF-250-KNP
<b>SUITABLE FOR</b>	Rebuilding, buffer layers before hardfacing on steels with high carbon content, heavy impact loads, manganese steels
<b>APPROVALS</b>	No Approvals Found

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

C	Si	Mn	Cr	Ni	Fe
1	0.4	13.5	4.5	0.5	Rem.

**ALL WELD MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0,2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)	Hardness Brinell
As Welded /				Avg. 230

**REDRYING TEMPERATURE** 140°C / 24 hr

**GAS ACCORDING EN 14175**



# CEWELD OA Mn14

OA MN14 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663402981

OA MN14 1,6MM

Type	KG/unit	EANCode
BS-300	15	8720663403018

OA MN14 2,8MM

Type	KG/unit	EANCode
BS-300	15	8720663403025