






# CEWELD OA Mn14

TYPE	Self-shielded and slag forming flux-cored wire for gas-shielded welding				
APPLICATIONS	Welding parts of manganese steel that are exposed to impact and shock-like wear				
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. Hardness HB: After workhardening: 450HB				
CLASSIFICATION	EN ISO DIN	14700: T Fe9 8555: MF 7-GF-250-KNP			
SUITABLE FOR	Rebuilding, buffer layers before hardfacing on steels with high carbon content, heavy impact loads, manganese steels				
APPROVALS	No Approvals Found				
WELDING POSITIONS	<div>PAPBPC</div>				
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C 1	Si 0.4	Mn 13.5	Cr 4.5	Ni 0.5 Fe Rem.
ALL WELD MECHANICAL PROPERTIES	Heat Treatment As Welded /	R <sub>P0,2</sub> MPa	R <sub>m</sub> MPa	A5 (%)	Hardness Brinell Hardness 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