


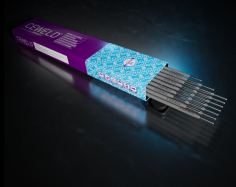


CEWELD E DUR Mn14

TYPE	Basic coated electrode with high impact resistance.				
APPLICATIONS	This electrode with a recovery of 140% can be used for joining and overlay on manganese steels that are worn out and need to be rebuild. Heat input should be low.				
PROPERTIES	There is no limit for the number of layers that can be applied in case of rebuilding but heat input should be kept low (as for Mn steel). The weld deposit is offers strain hardening properties from 250 till 450 HB				
CLASSIFICATION	AWS	A 5.13: E FeMn-A			
	EN ISO	14700: E Fe9			
	DIN	8555: E 7-UM-250-K			
	F-nr	71			
SUITABLE FOR	austenitic manganese steel, high impact loads, hammers, crushers, rebuilding, hardfacing, rails, crossings, Breaker teeth, etc..				
APPROVALS	No Approvals Found				
WELDING POSITIONS	  				
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	Ni	Fe
	0.8	0.4	13.5	3	Rem.
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} MPa	R _m MPa	A5 (%)	Hardness Brinell Hardness
	As Welded /				Avg. 260
REDRYING TEMPERATURE	300°C / 2 hr				
GAS ACCORDING EN 14175					



CEWELD E DUR Mn14

E DUR MN14 2,5 X 350MM

Type	KG/unit	EANCode
Can	2,5	8720663401953

E DUR MN14 3,2 X 450MM

Type	KG/unit	EANCode
Can	2,5	8720663401960

E DUR MN14 4,0 X 450MM

Type	KG/unit	EANCode
Can	2	8720663401977