




CEWELD E DUR Mn14

TYPE	Strain hardening Basic coated electrode with high impact resistance.				
APPLICATIONS	CEWELD® E DUR Mn14 is suitable for build-up welding of worn workpieces made of high-manganese steels and parts that are predominantly exposed to impact and shock wear, such as: Excavator teeth and cutting edges, blow bars, excavator bolts, crusher jaws and cones, frogs and cross pieces.				
PROPERTIES	CEWELD® E DUR Mn14 has no limit to the number of layers that can be deposited in the event of rebuilding, but the heat input should be kept low (as with Mn steel). The weld metal offers work hardening properties from 250 to 450 HB. Recovery of: 140 %				
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