
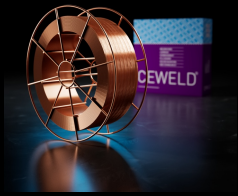




# CEWELD AA M650

TYPE	Medium -alloyed seamless fluxcored wire on a C-Cr-Mo-W-V basis offering high hardness up to 550°C.						
APPLICATIONS	Recommended for parts subject to strong mineral abrasion and erosion that faces increased working temperatures up to 450°C.						
PROPERTIES	Very good abrasion resistance in combination with impact even at higher temperatures up to 550°C. To much layers should be avoided, preheat is necessary to avoid cracking. A buffer layer with AA M690 or AA M37-42 is recommended in case of sensible base material or old hardfacing layers.						
CLASSIFICATION	AWS	A 5.21: ERFe-8					
	EN ISO	14700: T Fe8					
	DIN	MSG 3-GF-60-GPZ					
	W.Nr.	~1.2606					
SUITABLE FOR	HRc 58-62, Cement pumps, crusher bars, hammer and blooming table rolls, mineral and brick industry, stone crushers.						
APPROVALS	No Approvals Found						
WELDING POSITIONS							
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	Cr	Mo	V	W
	0.5	1.25	1.3	5.7	1.4	0.3	1.3
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R <sub>p0,2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)	Hardness Brinell Hardness		
	As Welded /				Avg. 650		
REDRYING TEMPERATURE	Not required						
GAS ACCORDING EN 14175	M21						



# CEWELD AA M650

AA M650 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663424198