




CEWELD AA SS 6356

TYPE	Flux-cored welding wire for rebuilding and hardfacing.						
APPLICATIONS	CEWELD® AA SS 6356 is a flux-cored wire electrode for hardfacing tools that needs to be machined afterwards. Such as : Die casting molds, edges, and cutting tools						
PROPERTIES	The weld metal deposited by CEWELD® AA SS 6356 consists of a martensite-hardening alloy that can be drilled, turned, milled, and filed in the welded condition. Heat treatment can significantly increase the hardness of the weld metal, and nitriding can increase it further. As welded: ~ 34 HRc 480°C/3h:~53 HRc Nitriding: ~ 63 HRc						
CLASSIFICATION	EN ISO		14700: T Z Fe5				
SUITABLE FOR	Tool steel						
APPROVALS	No Approvals Found						
WELDING POSITIONS	<div>PAPBPC</div>						
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	Ni	Mo	Fe	Co
	0.03	1	0.4	18	4	Rem.	12
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} MPa	R _m MPa	A ₅ (%)		Hardness Rockwell C	
	As Welded /					Avg. 34	
REDRYING TEMPERATURE	Not required						
GAS ACCORDING EN 14175	M21						