



CEWELD AA SS 50

TYPE Tungsten alloyed cored wire for hardfacing applications..

ANWENDUNGEN Rebuilding wornout parts that faces wear and impact combined with increased working temperatures.

EIGENSCHAFTEN Machinable ,Heat resistant weld deposit with excelent wear resistance. The weld deposit can be heat treated to offer maximum service protection.

KLASSIFIKATION EN ISO 14700: T Fe3
DIN MSG 3–GF-45-T
W.Nr. 1.2567

GEEIGNET FÜR **45-52 HRc**
1.2567, 1.2365, 1.2713, 1.2714, 1.2581
30WCrV17 2, 32CrMoV12-283, 55NiCrMoV6, 55NiCrMoV7, X30WCrV9-3

ZULASSUNGEN

SCHWEISSPOSITIONEN



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	V	W	Fe
0.3	0.75	0.8	2.5	0.6	4.5	Rem.

MECHANISCHE GÜTEWERTE

Heat Treatment	R _{PO,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded				47 HRc
580°C±15°C 1h				53 HRc

RÜCKTROCKNUNG 140°C / 2 hr

Hardening : 1060° C-1120° C°, hot bath, compressed air. Tempering : approx. 3 h / temperature depending on desired working hardness. Soft annealing : 2 - 4 h at 800° C -840° C / furnace cooling

GAS ACC. EN ISO 14175 M13