



# CEWELD SS 6356 Tig

|                                                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |    |                         |    |                      |     |        |          |     |
|------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----|-------------------------|----|----------------------|-----|--------|----------|-----|
| TYPE                                                 | Cobalt alloyed age hardenable hardfacing alloy for Mig and Tig welding.                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |    |                         |    |                      |     |        |          |     |
| ANWENDUNGEN                                          | High alloyed, age-hardenable alloy for high wear resistant clad layers combined with galling and high working temperatures.                                                                                                                                                                                                                                                                                                                                                                                                              |    |                         |    |                      |     |        |          |     |
| EIGENSCHAFTEN                                        | The weld deposit is, in the as-welded condition machinable, and the subsequent artificial aging optimises the resistance to hot wear and alternating temperatures.                                                                                                                                                                                                                                                                                                                                                                       |    |                         |    |                      |     |        |          |     |
| KLASSIFIKATION                                       | EN ISO<br>W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |    | 14700: S Fe5<br>~1.6356 |    |                      |     |        |          |     |
| GEEIGNET FÜR                                         | All hot- and cold-work steels. GG and GGG cast iron materials.<br>Similar materials: 1.2706 / 1.2709 / Böhler W720/21/22 / 1.6354 / 1.6358 (AMS 6512-6514) / Thyrodur / Corrax.                                                                                                                                                                                                                                                                                                                                                          |    |                         |    |                      |     |        |          |     |
| ZULASSUNGEN                                          |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |    |                         |    |                      |     |        |          |     |
| SCHWEISSPOSITIONEN                                   | <div> PA  PB  PC  PD  PE  PF</div> |    |                         |    |                      |     |        |          |     |
| TYPISCHE CHEMISCHE<br>ANALYSE DES<br>FÜLLMETALLS (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | Ni | Co                      | Mo | Mn                   | Si  | Fe     | Ti       | Cr  |
|                                                      | 0.01                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | 18 | 12                      | 4  | 0.03                 | 0.4 | Rem.   | 1.6      | 0.2 |
| MECHANISCHE GÜTEWERTE                                | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |    | R <sub>p0,2</sub> (MPa) |    | R <sub>m</sub> (MPa) |     | A5 (%) | Hardness |     |
|                                                      | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |    | 885                     |    | 990                  |     |        | 38 HRc   |     |
| RÜCKTROCKNUNG                                        | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |    |                         |    |                      |     |        |          |     |
| GAS ACC. EN ISO 14175                                | I1, M13, M12                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |    |                         |    |                      |     |        |          |     |