



# 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**

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

C	Si	Mn	Ni	Fe
0.8	0.4	13.5	3	Rem.

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Hardness
As Welded				260 HB

**REDRYING** 300°C / 2 hr

**GAS ACC.** EN ISO 14175



# CEWELD E DUR Mn14

E DUR MN14 2,5 X 350MM	Packaging	KG/unit	EanCode
	Can	2,5	8720663401953
E DUR MN14 3,2 X 450MM	Packaging	KG/unit	EanCode
	Can	2,5	8720663401960
E DUR MN14 4,0 X 450MM	Packaging	KG/unit	EanCode
	Can	2	8720663401977