



CEWELD E DUR MnCr

TYPE Basic-coated strain hardening high recovery stick electrode for hardfacing.(Fe 9)

APPLICATIONS CEWELD® E DUR MnCr is a basic electrode for rebuilding and joining cold straining Mn steels or rebuilding parts that are subject to high impact and rolling wear.
Such as: Excavator teeth, beating arm, dredger bolts, crusher jaws and cones, sand blasting and shot peening devices;
Railway systems: crossing frogs and four-way pieces.

PROPERTIES CEWELD® E DUR MnCr has no limit to the number of layers that can be applied in the event of rebuilding, but the heat input should be kept low (as with Mn steel, the interpass temperature should be < 250 °C).
Hardness: 250 [HB] up to 450 [HB] workhardened
Recovery: 140%

CLASSIFICATION

AWS	A 5.13: E FeMnCr
EN ISO	14700: E Fe9
DIN	8555: E 7-UM-250-K
F-nr	71

SUITABLE FOR Rebuilding and joining cold straining Mn steels or rebuilding parts that are subject to high impact and rolling wear. Breaker teeth, Crushers, Hammers, Crossings, Rails.

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Mn	Cr	Fe	Si
0.75	17.5	14	Rem.	0.4

MECHANICAL PROPERTIES

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded				270 HB

REDRYING 300°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD E DUR MnCr

E DUR MNCR 2,5 X 350MM	Packaging	KG/unit	EanCode
	Can	2,5	8720663401496
E DUR MNCR 3,2 X 350MM	Packaging	KG/unit	EanCode
	Can	2,5	8720663401502
E DUR MNCR 4,0 X 450MM	Packaging	KG/unit	EanCode
	Can	3,0	8720663401519