CEWELD SACW MnCr

certilas® THE FILLER METAL SPECIALIST

TYPE

Flux-cored wire for submerged-arc welding.

APPLICATIONS

Building up worn out parts that suffer from wear combined with high impact, buffer layers etc.

PROPERTIES

Austenitic deposit with strain hardening properties and no limits in the number of layers. The deposit is non magnetic and can not be flame cut. Extreme resistance to heavy impact loads. The weld deposit offers fair corrosion resistance and has strain hardening properties. This alloy should be applied at highest impact and pressure loads applications. Best to be used with welding flux FL 915

CLASSIFICATION

EN ISO 14700: T Fe9

SUITABLE FOR

Rebuilding rails, crossings, crushing hammers, dredger teeth, rollers, blast furnace, mantles, Hardfacing manganese hard stee, buffer layers etc..

APPROVALS

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Ni	Mo	V	Fe
0.5	0.9	16	15	1.2	1.5	0.2	Rem.

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded				240 HB
As Welded				500 HB

REDRYING

140°C / 24 hr

GAS ACC. EN ISO 14175