



CEWELD MA HSS

TYPE	Solid drawn hardfacing alloy based on a High Speed Steel (HSS) weld deposit.
APPLICATIONS	Cutting edges, tool making, gouges, turning chisel, broaches, schredder knives, scissors etc.
PROPERTIES	Extreme hard and heat resistant alloy that offers excellent cutting properties when cutting steel cables, bars, wooden bars etc. The CEWELD MA HSS is only machinable by grinding. Soft annealed 770°C - 840°C/2 - 4h = 27 HRc Hardened 1190°C - 1230°C/air,Oil,Hot bath = 60 HRc Tempered two times 530°C - 560°C = 62 HRc

CLASSIFICATION	AWS A 5.21: ERFc-8 EN ISO 14700: S Fe3 DIN 8555: MSG 4-UM-60-65-ST W.Nr. 1.3348 F-nr 71
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SUITABLE FOR	57-62 HRc hardfacing alloy for steel cutting knives, scissors, HSS, high speed tool steel, 1.3348, molds, edges and repairs on ; X85WDCV06-04-02 ; V6Mo5Cr4V2 ; HS 6-5-2 ; M2, J438B; X85WDCV06-04-02 ; BM2 ; SKH 51 ; R 6 M 5
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APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Mn	Cr	Mo	V	Fe	W	Si
1	0.3	4	8	2	Rem.	1.8	0.3

MECHANICAL PROPERTIES

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A5 (%)	Hardness
As Welded				60 HRc

REDRYING	Not required
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GAS ACC. EN ISO 14175	M21
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CEWELD MA HSS

MA HSS 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663401755

MA HSS 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663401762