



CEWELD OA Mn14

TYPE	Self-shielded and slag forming flux-cored wire for gas-shielded welding					
ANWENDUNGEN	Welding parts of manganesesteel that are exposed to impact and shock-like wear					
EIGENSCHAFTEN	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.					
KLASSIFIKATION	EN ISO DIN	14700: T Fe9 8555: MF 7-GF-250-KNP				
GEEIGNET FÜR	Rebuilding, buffer layers before hardfacing on steels with high carbon content, heavy impact loads, manganese steels					
ZULASSUNGEN						
SCHWEISSPOSITIONEN	PAPBPC					
TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%)	C	Si	Mn	Cr	Ni	Fe
	1	0.4	13.5	4.5	0.5	Rem.
MECHANISCHE GÜTEWERTE	Heat Treatment		R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Hardness
	As Welded					230 HB
RÜCKTROCKNUNG	140°C / 24 hr					
HARDNESS HB	After hardening: 450HB					
GAS ACC. EN ISO 14175						



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OA MN14 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663402981

OA MN14 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663403018

OA MN14 2,8MM

Packaging	KG/unit	EanCode
BS-300	15	8720663403025