



# CEWELD SACW MnCr

|                                                    |                                                                                                                                                                                                                                                                                                                                                                                                            |              |                         |                      |        |          |     |      |
|----------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|-------------------------|----------------------|--------|----------|-----|------|
| TYPE                                               | Flux-cored wire for submerged-arc welding.                                                                                                                                                                                                                                                                                                                                                                 |              |                         |                      |        |          |     |      |
| ANWENDUNGEN                                        | Building up worn out parts that suffer from wear combined with high impact, buffer layers etc.                                                                                                                                                                                                                                                                                                             |              |                         |                      |        |          |     |      |
| 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. 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 |              |                         |                      |        |          |     |      |
| KLASSIFIKATION                                     | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                     | 14700: T Fe9 |                         |                      |        |          |     |      |
| GEEIGNET FÜR                                       | Rebuilding rails, crossings, crushing hammers, dredger teeth, rollers, blast furnace, mantles, Hardfacing manganese hard stee, buffer layers etc..                                                                                                                                                                                                                                                         |              |                         |                      |        |          |     |      |
| ZULASSUNGEN                                        |                                                                                                                                                                                                                                                                                                                                                                                                            |              |                         |                      |        |          |     |      |
| SCHWEISSPOSITIONEN                                 |                                                                                                                                                         |              |                         |                      |        |          |     |      |
| TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%) | C                                                                                                                                                                                                                                                                                                                                                                                                          | Si           | Mn                      | Cr                   | Ni     | Mo       | V   | Fe   |
|                                                    | 0.5                                                                                                                                                                                                                                                                                                                                                                                                        | 0.9          | 16                      | 15                   | 1.2    | 1.5      | 0.2 | Rem. |
| MECHANISCHE GÜTEWERTE                              | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                             |              | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A5 (%) | Hardness |     |      |
|                                                    | As Welded                                                                                                                                                                                                                                                                                                                                                                                                  |              |                         |                      |        | 240 HB   |     |      |
|                                                    | As Welded                                                                                                                                                                                                                                                                                                                                                                                                  |              |                         |                      |        | 500 HB   |     |      |
| RÜCKTROCKNUNG                                      | 140°C / 24 hr                                                                                                                                                                                                                                                                                                                                                                                              |              |                         |                      |        |          |     |      |
| GAS ACC. EN ISO 14175                              |                                                                                                                                                                                                                                                                                                                                                                                                            |              |                         |                      |        |          |     |      |