CEWELD AA SS 50

certilas® THE FILLER METAL SPECIALIST

TYPE	Tungsten alloyed cored wire for hardfacing applications..
APPLICATIONS	Rebuilding wornout parts that faces wear and impact combined with increased working temperatures.
PROPRIÉTÉS	Machinable ,Heat resistant weld deposit with excelent wear resistance. The weld deposit can be heat treated to offer maximum service protection.

CLASSIFICATION

EN ISO	14700: T Fe3
DIN	MSG 3–GF-45-T
W.Nr.	1.2567

CONVIENT POUR

45-52 HRc
1.2567, 1.2365, 1.2713, 1.2714, 1.2581
30WCrV17 2, 32CrMoV12-283, 55NiCrMoV6, 55NiCrMoV7, X30WCrV9-3

AGRÉMENTS

POSITIONS DE SOUDAGE

ANALYSE CHIMIQUE TYPIQUE DU MÉTAL DE SOUDURE (%)

C	Si	Mn	Cr	V	W	Fe
0.3	0.75	0.8	2.5	0.6	4.5	Rem.

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded				47 HRc
580°C±15°C 1h				53 HRc

ETUVAGE 140°C / 2 hr

Hardening : 1060° C-1120° C°, hot bath, compressed air. Tempering : approx. 3 h / temperature depending on desired working hardness. Soft annealing : 2 - 4 h at 800° C -840° C / furnace cooling

GAS ACC. EN ISO 14175 M13