



# CEWELD AA GGG

|                                                    |                                                                                                                                                                                                                                                                      |                |                         |                      |        |          |   |
|----------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|-------------------------|----------------------|--------|----------|---|
| TYPE                                               | Medium-alloy high-basicity flux-cored wire with slag for hardfacing using Ar-CO2 mix                                                                                                                                                                                 |                |                         |                      |        |          |   |
| ANWENDUNGEN                                        | Build-up of cast iron and alloyed grey-cast iron Well suited for warm and in special applications for cold welding. Used to fill-in voids and pores, build-up of worn-down parts.                                                                                    |                |                         |                      |        |          |   |
| EIGENSCHAFTEN                                      | Very good welding and wetting characteristics and high resistance to cracks and fissures. Extreme good deposition rate compare to MMA.High strength and good bonding weld metal..                                                                                    |                |                         |                      |        |          |   |
| KLASSIFIKATION                                     | EN ISO                                                                                                                                                                                                                                                               | 1071: T C Fe-2 |                         |                      |        |          |   |
| GEEIGNET FÜR                                       | DIN GG15 – GG40, GGG40 - GGG70, GTS35 - GTS 65<br>ASTM: A48 Class 25 B - A48 Class 60 B, A536 Grad 60-80<br>FGL 150- FGL 400, FGS 400 12 - FGS 600 3, MN350 10 - MN650 3                                                                                             |                |                         |                      |        |          |   |
| ZULASSUNGEN                                        |                                                                                                                                                                                                                                                                      |                |                         |                      |        |          |   |
| SCHWEISSPOSITIONEN                                 | <div>PAPBPC</div> |                |                         |                      |        |          |   |
| TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%) | C                                                                                                                                                                                                                                                                    | Si             | Mn                      | Mo                   | Fe     | Cr       | V |
|                                                    | 0.06                                                                                                                                                                                                                                                                 | 0.4            | 0.6                     | 0.1                  | Rem.   | 0.6      | 6 |
| MECHANISCHE GÜTEWERTE                              | Heat Treatment                                                                                                                                                                                                                                                       |                | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A5 (%) | Hardness |   |
|                                                    | As Welded                                                                                                                                                                                                                                                            |                |                         |                      |        | 200 HB   |   |
| RÜCKTROCKNUNG                                      | Not required                                                                                                                                                                                                                                                         |                |                         |                      |        |          |   |
| GAS ACC. EN ISO 14175                              | M21                                                                                                                                                                                                                                                                  |                |                         |                      |        |          |   |