



CEWELD AA B57-62

TYPE	Seamless medium alloyed basic fluxcored wire with slag for hardfacing using Ar-CO2 mix								
ANWENDUNGEN	Rebuilding and cladding parts against strong abrasion and heavy impact.								
EIGENSCHAFTEN	Due to the high resistance to cracking and toughness, all weld metal requires no buffer layer except on materials considered critical. In this situation CEWELD® ER 100 S-G is recommended. Suited for wear parts subject to heavy impact and shock. The interpass temperature should be maximum 250°C. The weld metal is machinable by special carbide tools, hardening is possible. The maximum hardness is dependent on the base metal and is achieved in the first layer. For material considered critical to cracking we advise to buffer with one layer CEWELD® AA B460.								
KLASSIFIKATION	EN ISO	14700: T Fe4							
GEEIGNET FÜR	55-62 HRc hardfacing alloy against heavy impact and shock, bucket, loaders, crusher jaws, crusher cones, pumps, sand, snow scratchers, stone cutting tools etc.								
ZULASSUNGEN									
SCHWEISSPOSITIONEN	 PA  PB								
TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%)	C	Si	Mn	Cr	Mo				
	0.5	0.6	1.5	6	0.5				
MECHANISCHE GÜTEWERTE	Heat Treatment	$R_{P0.2}$ (MPa)	R_m (MPa)	A5 (%)	Hardness				
	As Welded				60 HRc				
RÜCKTROCKNUNG	Not required								
GAS ACC. EN ISO 14175	M21								