

# CEWELD AA SS 6356

TYPE	Flux-cored welding wire for rebuilding and hardfacing.																
APPLICATIONS	CEWELD® AA SS 6356 is a flux-cored wire electrode for hardfacing tools that needs to be machined afterwards. Such as : Die casting molds, edges, and cutting tools ....																
PROPERTIES	<p>The weld metal deposited by CEWELD® AA SS 6356 consists of a martensite-hardening alloy that can be drilled, turned, milled, and filed in the welded condition. Heat treatment can significantly increase the hardness of the weld metal, and nitriding can increase it further.</p> <p>As welded: ~ 34 HRc 480°C/3h:~53 HRc Nitriding: ~ 63 HRc</p>																
CLASSIFICATION	EN ISO	14700: T Z Fe5															
SUITABLE FOR	Tool steel																
APPROVALS																	
WELDING POSITIONS	 PA  PB  PC																
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C 0.03	Si 1	Mn 0.4	Ni 18	Mo 4	Fe Rem.	Co 12										
MECHANICAL PROPERTIES	<table border="1"> <thead> <tr> <th>Heat Treatment</th> <th><math>R_{P0,2}</math> (MPa)</th> <th><math>R_m</math> (MPa)</th> <th>A5 (%)</th> <th>Hardness</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td></td> <td></td> <td></td> <td>34 HRc</td> </tr> </tbody> </table>							Heat Treatment	$R_{P0,2}$ (MPa)	$R_m$ (MPa)	A5 (%)	Hardness	As Welded				34 HRc
Heat Treatment	$R_{P0,2}$ (MPa)	$R_m$ (MPa)	A5 (%)	Hardness													
As Welded				34 HRc													
REDRYING	Not required																
GAS ACC. EN ISO 14175	M21																