



# CEWELD AA M650

**TYPE** Medium -alloyed seamless fluxcored wire on a C-Cr-Mo-W-V basis offering high hardness up to 550°C.

**APPLICATIONS** Recommended for parts subject to strong mineral abrasion and erosion that faces increased working temperatures up to 450°C.

**PROPERTIES** Very good abrasion resistance in combination with impact even at higher temperatures up to 550°C. Too much layers should be avoided, preheat is necessary to avoid cracking. A buffer layer with AA M690 or AA M37-42 is recommended in case of sensible base material or old hardfacing layers.

**CLASSIFICATION**

|        |                             |
|--------|-----------------------------|
| AWS    | A 5.21: ERF <sub>e</sub> -8 |
| EN ISO | 14700: T Fe8                |
| DIN    | MSG 3-GF-60-GPZ             |
| W.Nr.  | ~1.2606                     |

**SUITABLE FOR** HRc 58-62, Cement pumps, crusher bars, hammer and blooming table rolls, mineral and brick industry, stone crushers.

**APPROVALS**

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

| C   | Si   | Mn  | Cr  | Mo  | V   | Fe   | W   |
|-----|------|-----|-----|-----|-----|------|-----|
| 0.5 | 1.25 | 1.3 | 5.7 | 1.4 | 0.3 | Rem. | 1.3 |

**MECHANICAL PROPERTIES**

| Heat Treatment | R <sub>p0.2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Hardness |
|----------------|-------------------------|----------------------|--------------------|----------|
| As Welded      |                         |                      |                    | 59 HRc   |

**REDRYING** Not required

**GAS ACC. EN ISO 14175** M21



# CEWELD AA M650

AA M650 1,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663424198 |