

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						
PROPRIÉTÉS	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. As welded: ~ 34 HRC 480°C/3h:~53 HRC Nitriding: ~ 63 HRC						
CLASSIFICATION	EN ISO	14700: T Z Fe5					
CONVIENT POUR	Tool steel						
AGRÉMENTS							
POSITIONS DE SOUDAGE	 PA  PB  PC						
ANALYSE CHIMIQUE TYPIQUE DU MÉTAL DE SOUDURE (%)	C	Si	Mn	Ni	Mo	Fe	Co
	0.03	1	0.4	18	4	Rem.	12
PROPRIÉTÉS MÉCANIQUES	Heat Treatment		R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Hardness	
	As Welded					34 HRC	
ETUVAGE	Not required						
GAS ACC. EN ISO 14175	M21						