



CEWELD SACW MnCr

TYPE	Flux-cored wire for submerged-arc welding.													
APPLICATIONS	Building up worn out parts that suffer from wear combined with high impact, buffer layers etc.													
PROPRIÉTÉS	Austenitic deposit with strain hardening properties and no limits in the number of layers. The deposit is non magnetic and can not be flame cut. Extreme resistance to heavy impact loads. The weld deposit offers fair corrosion resistance and has strain hardening properties. This alloy should be applied at highest impact and pressure loads applications. Best to be used with welding flux FL 915													
CLASSIFICATION	EN ISO	14700: T Fe9												
CONVIENT POUR	Rebuilding rails, crossings, crushing hammers, dredger teeth, rollers, blast furnace, mantles, Hardfacing manganese hard stee, buffer layers etc..													
AGRÉMENTS														
POSITIONS DE SOUDAGE														
ANALYSE CHIMIQUE TIPIQUE DU MÉTAL DE SOUDURE (%)	C	Si	Mn	Cr	Ni	Mo	V	Fe						
	0.5	0.9	16	15	1.2	1.5	0.2	Rem.						
PROPRIÉTÉS MÉCANIQUES	Heat Treatment	$R_{P0,2}$ (MPa)	R_m (MPa)	A5 (%)	Hardness									
	As Welded				240 HB									
	As Welded				500 HB									
ETUVAGE	140°C / 24 hr													
GAS ACC. EN ISO 14175														