



# CEWELD AA SS 50

|               |                                                                                                                                                  |                                         |  |
|---------------|--------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------|--|
| TYPE          | Tungsten alloyed cored wire for hardfacing applications..                                                                                        |                                         |  |
| TOEPASSINGEN  | Rebuilding wornout parts that faces wear and impact combined with increased working temperatures.                                                |                                         |  |
| EIGENSCHAPPEN | Machinable ,Heat resistant weld deposit with excelent wear resistance. The weld deposit can be heat treated to offer maximum service protection. |                                         |  |
| CLASSIFICATIE | EN ISO<br>DIN<br>W.Nr.                                                                                                                           | 14700: T Fe3<br>MSG 3–GF-45-T<br>1.2567 |  |

|               |                                                                                                                             |
|---------------|-----------------------------------------------------------------------------------------------------------------------------|
| GESCHIKT VOOR | <b>45-52 HRc</b><br>1.2567, 1.2365, 1.2713, 1.2714, 1.2581<br>30WCrV17 2, 32CrMoV12-283, 55NiCrMoV6, 55NiCrMoV7, X30WCrV9-3 |
|---------------|-----------------------------------------------------------------------------------------------------------------------------|

## GOEDKEURINGEN

## LASPOSITIES



## TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

| C   | Si   | Mn  | Cr  | V   | W   | Fe   |
|-----|------|-----|-----|-----|-----|------|
| 0.3 | 0.75 | 0.8 | 2.5 | 0.6 | 4.5 | Rem. |

## MECHANISCHE WAARDEN

| Heat Treatment | R <sub>P0.2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Hardness |
|----------------|-------------------------|----------------------|--------------------|----------|
| As Welded      |                         |                      |                    | 47 HRc   |
| 580°C±15°C 1h  |                         |                      |                    | 53 HRc   |

|           |              |
|-----------|--------------|
| HERDROGEN | 140°C / 2 hr |
|-----------|--------------|

Hardening : 1060° C-1120° C°, hot bath, compressed air. Tempering : approx. 3 h / temperature depending on desired working hardness. Soft annealing : 2 - 4 h at 800° C -840° C / furnace cooling

|                       |     |
|-----------------------|-----|
| GAS ACC. EN ISO 14175 | M13 |
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