



CEWELD E DUR Mn14

TYPE Basic coated electrode with high impact resistance.

ANWENDUNGEN This electrode with a recovery of 140% can be used for joining and overlay on manganese steels that are worn out and need to be rebuild. Heat input should be low.

EIGENSCHAFTEN There is no limit for the number of layers that can be applied in case of rebuilding but heat input should be kept low (as for Mn steel). The weld deposit is offers strain hardening properties from 250 till 450 HB

KLASSIFIKATION

AWS	A 5.13: E FeMn-A
EN ISO	14700: E Fe9
DIN	8555: E 7-UM-250-K
F-nr	71

GEEIGNET FÜR austenitic manganese steel, high impact loads, hammers, crushers, rebuilding, hardfacing, rails, crossings, Breaker teeth, etc..

ZULASSUNGEN

SCHWEISSPOSITIONEN



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Ni	Fe
0.8	0.4	13.5	3	Rem.

MECHANISCHE GÜTEWERTE

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded				260 HB

RÜCKTROCKNUNG 300°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD E DUR Mn14

E DUR MN14 2,5 X 350MM	Packaging	KG/unit	EanCode
	Can	2,5	8720663401953
E DUR MN14 3,2 X 450MM	Packaging	KG/unit	EanCode
	Can	2,5	8720663401960
E DUR MN14 4,0 X 450MM	Packaging	KG/unit	EanCode
	Can	2	8720663401977