

# CEWELD E DUR 49

<b>TYPE</b>	Rutile Fe, Cr, Co and Mo based electrode
<b>APPLICATIONS</b>	Hardfacing of forging presses, hot piercing dies, stretching rolls, pinch rolls, hot strip mill table rolls and back-up rolls
<b>PROPERTIES</b>	Rutile Fe, Cr, Co and Mo based elektotrode with high hot wear resistance, tensile strenght and a high resistance against sliding wear of metallic objects.It has a good retention of hardness up to 650°C and is non scaling up to 900° C thermo shock resistant and resistant to sudden changes of temperature.Work hardening. Not crack sensible.The number of layers can be done as necessary. The deposit can beadditionally treated with cutting tools.
<b>CLASSIFICATION</b>	EN ISO 14700: E Fe3
<b>SUITABLE FOR</b>	1.2311 40CrMnMo 7 1.2343 X38CrMoV 5 1 1.2344 X40CrMoV 5 1 1.2365 X32CrMoV 3 3 1.2367 X38CrMoV 5 3 1.2606 X37CrMoW 5 1 1.2713 55NiCrMoV 6 1.2714 56NiCrMoV 7

**APPROVALS**

**WELDING POSITIONS**



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

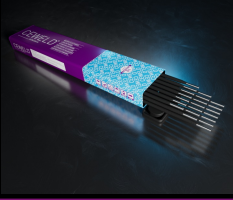
C	Si	Mn	Cr	Mo	Fe	Co
0.15	0.6	0.6	14	2.3	Rem.	13

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Hardness
As Welded				48 HRc

**REDRYING** 300°C / 2 hr

**GAS ACC.** EN ISO 14175



# CEWELD E DUR 49

E DUR 49 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	3	8720663402141