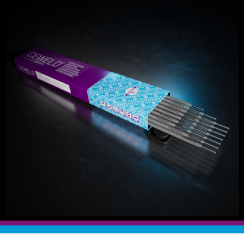


CEWELD E DUR Mn14

certilas® THE FILLER METAL SPECIALIST

TYPE

Basic coated electrode with high impact resistance.

APPLICATIONS

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.

PROPERTIES

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

CLASSIFICATION

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

SUITABLE FOR

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

APPROVALS

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Ni	Fe
0.8	0.4	13.5	3	Rem.

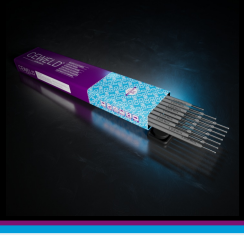
MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded				260 HB

REDRYING

300°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD E DUR Mn14

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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