



# CEWELD E DUR Mn14

**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.

**PROPRIÉTÉS** 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

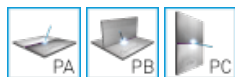
**CLASSIFICATION**

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

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

**AGRÉMENTS**

**POSITIONS DE SOUDAGE**



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

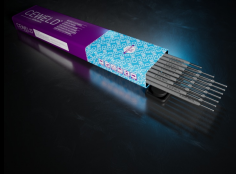
C	Si	Mn	Ni	Fe
0.8	0.4	13.5	3	Rem.

**PROPRIÉTÉS MÉCANIQUES**

Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Hardness
As Welded				260 HB

**ETUVAGE** 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