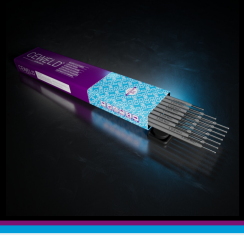


CEWELD E DUR MnCr

certilas® THE FILLER METAL SPECIALIST

TYPE

Basic Hardfacing electrode with high impact and wear resistance

APPLICATIONS

Basic electrode for rebuilding and joining cold straining Mn steels or rebuilding parts that are subject to high impact and rolling wear.

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, interpass temperature should be kept < 250 °C).

CLASSIFICATION

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

CONVIENT POUR

Rebuilding and joining cold straining Mn steels or rebuilding parts that are subject to high impact and rolling wear. Breaker teeth, Crushers, Hammers, Crossings, Rails.

AGRÉMENTS

POSITIONS DE SOUDAGE

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Mn	Cr	Fe	Si
0.75	17.5	14	Rem.	0.4

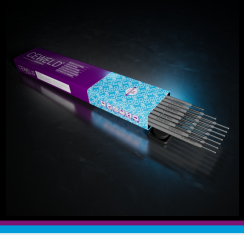
PROPRIÉTÉS MÉCANIQUES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded				270 HB

ETUVAGE

300°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD E DUR MnCr

E DUR MNCR 2,5 X 350MM

Packaging	KG/unit	EanCode
Can	2,5	8720663401496

E DUR MNCR 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2,5	8720663401502

E DUR MNCR 4,0 X 450MM

Packaging	KG/unit	EanCode
Can	3,0	8720663401519