



# CEWELD OA MnCr

TYPE

Tubular wire weldable without protective gas for rebuilding and buffer layers before hardfacing with extreme resistance to heavy impact loads.

ANWENDUNGEN

Rebuilding heavy steel parts, buffer layers, rails, rails crossings, dredger teeth, blast furnace mantles etc..

EIGENSCHAFTEN

Austenitic deposit with strain hardening properties and no limmits in the number of layers. The deposit is non magnetic and can not be flame cut.

KLASSIFIKATION

EN ISO

14700: T Fe9

DIN

8555: MF 7-GF-250-KNP

GEEIGNET FÜR

Rebuilding, buffer layers, rails, rails crossings, dredger teeth, blast furnace mantles

ZULASSUNGEN

SCHWEISSPOSITIONEN

PA

PB

PC

TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%)

|      |     |      |      |      |      |      |      |
|------|-----|------|------|------|------|------|------|
| C    | Si  | Mn   | Cr   | Ni   | Mo   | V    | Fe   |
| 0.45 | 0.4 | 15.7 | 14.8 | 1.25 | 0.55 | 0.25 | Rem. |

MECHANISCHE GÜTEWERTE

|                |                         |                      |                    |          |
|----------------|-------------------------|----------------------|--------------------|----------|
| Heat Treatment | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Hardness |
| As Welded      |                         |                      |                    | 240 HB   |

RÜCKTROCKNUNG

140°C / 24 hr

HARDNESS HB

after hardening: 500HB

GAS ACC. EN ISO 14175



# CEWELD OA MnCr

OA MNCR 1,6MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663402967 |

OA MNCR 2,8MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663402974 |