

CEWELD AA SS 6356

TYPE	Flux-cored welding wire for rebuilding and hardfacing.						
APPLICATIONS	CEWELD® AA SS 6356 is a flux-cored wire electrode for hardfacing tools that needs to be machined afterwards. Such as : Die casting molds, edges, and cutting tools						
PROPERTIES	The weld metal deposited by CEWELD® AA SS 6356 consists of a martensite-hardening alloy that can be drilled, turned, milled, and filed in the welded condition. Heat treatment can significantly increase the hardness of the weld metal, and nitriding can increase it further. As welded: ~ 34 HRc 480°C/3h:~53 HRc Nitriding: ~ 63 HRc						
CLASSIFICATION	EN ISO	14700: T Z Fe5					
SUITABLE FOR	Tool steel						
APPROVALS							
WELDING POSITIONS	PAPBPC						
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	Ni	Mo	Fe	Co
	0.03	1	0.4	18	4	Rem.	12
MECHANICAL PROPERTIES	Heat Treatment		R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Hardness	
	As Welded					34 HRc	
REDRYING	Not required						
GAS ACC. EN ISO 14175	M21						