



# CEWELD SACW MnCr

|                |                                                                                                                                                                                                                                                                                                                                                                                                            |
|----------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| TYPE           | Flux-cored wire for submerged-arc welding.                                                                                                                                                                                                                                                                                                                                                                 |
| APPLICATIONS   | Building up worn out parts that suffer from wear combined with high impact, buffer layers etc.                                                                                                                                                                                                                                                                                                             |
| PROPERTIES     | Austenitic deposit with strain hardening properties and no limits in the number of layers. The deposit is non magnetic and can not be flame cut. Extreme resistance to heavy impact loads. The weld deposit offers fair corrosion resistance and has strain hardening properties. This alloy should be applied at highest impact and pressure loads applications. Best to be used with welding flux FL 915 |
| CLASSIFICATION | EN ISO 14700: T Fe9                                                                                                                                                                                                                                                                                                                                                                                        |
| SUITABLE FOR   | Rebuilding rails, crossings, crushing hammers, dredger teeth, rollers, blast furnace, mantles, Hardfacing manganese hard steel, buffer layers etc..                                                                                                                                                                                                                                                        |

## APPROVALS

## WELDING POSITIONS



## TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

| C   | Si  | Mn | Cr | Ni  | Mo  | V   | Fe   |
|-----|-----|----|----|-----|-----|-----|------|
| 0.5 | 0.9 | 16 | 15 | 1.2 | 1.5 | 0.2 | Rem. |

## MECHANICAL PROPERTIES

| Heat Treatment | R <sub>P0.2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Hardness |
|----------------|-------------------------|----------------------|--------------------|----------|
| As Welded      |                         |                      |                    | 240 HB   |
| As Welded      |                         |                      |                    | 500 HB   |

REDRYING 140°C / 24 hr

GAS ACC. EN ISO 14175