



CEWELD AA M650

TYPE	Medium -alloyed seamless fluxcored wire on a C-Cr-Mo-W-V basis offering high hardness up to 550°C.		
APPLICATIONS	Recommended for parts subject to strong mineral abrasion and erosion that faces increased working temperatures up to 450°C.		
PROPERTIES	Very good abrasion resistance in combination with impact even at higher temperatures up to 550°C. To much layers should be avoided, preheat is necessary to avoid cracking. A buffer layer with AA M690 or AA M37-42 is recommended in case of sensible base material or old hardfacing layers.		
CLASSIFICATION	AWS EN ISO DIN W.Nr.	A 5.21: ERF _e -8 14700: T Fe8 MSG 3-GF-60-GPZ ~1.2606	
SUITABLE FOR	HRc 58-62, Cement pumps, crusher bars, hammer and blooming table rolls, mineral and brick industry, stone crushers.		

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Mo	V	Fe	W
0.5	1.25	1.3	5.7	1.4	0.3	Rem.	1.3

MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded				59 HRc

REDRYING Not required

GAS ACC. EN ISO 14175 M21



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AA M650 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663424198