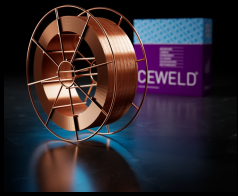


# CEWELD AA M650

|                                                          |                                                                                                                                                                                                                                                                                                                                                         |                                                              |                            |                         |           |          |      |     |
|----------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------|----------------------------|-------------------------|-----------|----------|------|-----|
| TYPE                                                     | Medium -alloyed seamless fluxcored wire on a C-Cr-Mo-W-V basis offering high hardness up to 500°C.                                                                                                                                                                                                                                                      |                                                              |                            |                         |           |          |      |     |
| ANWENDUNGEN                                              | Recommended for parts subject to strong mineral abrasion and erosion that faces increased working temperatures up to 500°C.                                                                                                                                                                                                                             |                                                              |                            |                         |           |          |      |     |
| EIGENSCHAFTEN                                            | Very good abrasion resistance in combination with impact even at higher temperatures up to 500°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.                                                         |                                                              |                            |                         |           |          |      |     |
| KLASSIFIKATION                                           | AWS<br>EN ISO<br>DIN<br>W.Nr.                                                                                                                                                                                                                                                                                                                           | A 5.21: ERFe-8<br>14700: T Fe8<br>MSG 3-GF-60-GPZ<br>~1.2606 |                            |                         |           |          |      |     |
| GEEIGNET FÜR                                             | HRc 58-62, Cement pumps, crusher bars, hammer and blooming table rolls, mineral and brick industry, stone crushers.                                                                                                                                                                                                                                     |                                                              |                            |                         |           |          |      |     |
| ZULASSUNGEN                                              |                                                                                                                                                                                                                                                                                                                                                         |                                                              |                            |                         |           |          |      |     |
| SCHWEISSPOSITIONEN                                       | <div>PAPBPCPF</div> |                                                              |                            |                         |           |          |      |     |
| TYPISCHE CHEMISCHE<br>ANALYSE DES<br>SCHWEISSMETALLS (%) | C                                                                                                                                                                                                                                                                                                                                                       | Si                                                           | Mn                         | Cr                      | Mo        | V        | Fe   | W   |
|                                                          | 0.5                                                                                                                                                                                                                                                                                                                                                     | 1.25                                                         | 1.3                        | 5.7                     | 1.4       | 0.3      | Rem. | 1.3 |
| MECHANISCHE GÜTEWERTE                                    | Heat Treatment                                                                                                                                                                                                                                                                                                                                          |                                                              | R <sub>P0,2</sub><br>(MPa) | R <sub>m</sub><br>(MPa) | A5<br>(%) | Hardness |      |     |
|                                                          | As Welded                                                                                                                                                                                                                                                                                                                                               |                                                              |                            |                         |           | 59 HRc   |      |     |
| RÜCKTROCKNUNG                                            | Not required                                                                                                                                                                                                                                                                                                                                            |                                                              |                            |                         |           |          |      |     |
| GAS ACC. EN ISO 14175                                    | M21                                                                                                                                                                                                                                                                                                                                                     |                                                              |                            |                         |           |          |      |     |



# CEWELD AA M650

AA M650 1,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663424198 |