



# CEWELD OA Mn14

|                                             |                                                                                                                                                                                                                                                                      |                                       |                         |                      |                    |          |
|---------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------|-------------------------|----------------------|--------------------|----------|
| TYPE                                        | Self-shielded and slag forming flux-cored wire for gas-shielded welding                                                                                                                                                                                              |                                       |                         |                      |                    |          |
| APPLICATIONS                                | Welding parts of manganese steel that are exposed to impact and shock-like wear                                                                                                                                                                                      |                                       |                         |                      |                    |          |
| 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.<br>Hardness HB: After workhardening: 450HB                                                                          |                                       |                         |                      |                    |          |
| CLASSIFICATION                              | EN ISO<br>DIN                                                                                                                                                                                                                                                        | 14700: T Fe9<br>8555: MF 7-GF-250-KNP |                         |                      |                    |          |
| SUITABLE FOR                                | Rebuilding, buffer layers before hardfacing on steels with high carbon content, heavy impact loads, manganese steels                                                                                                                                                 |                                       |                         |                      |                    |          |
| APPROVALS                                   |                                                                                                                                                                                                                                                                      |                                       |                         |                      |                    |          |
| WELDING POSITIONS                           | <div>PAPBPC</div> |                                       |                         |                      |                    |          |
| TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%) | C                                                                                                                                                                                                                                                                    | Si                                    | Mn                      | Cr                   | Ni                 | Fe       |
|                                             | 1                                                                                                                                                                                                                                                                    | 0.4                                   | 13.5                    | 4.5                  | 0.5                | Rem.     |
| MECHANICAL PROPERTIES                       | Heat Treatment                                                                                                                                                                                                                                                       |                                       | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Hardness |
|                                             | As Welded                                                                                                                                                                                                                                                            |                                       |                         |                      |                    | 230 HB   |
| REDRYING                                    | 140°C / 24 hr                                                                                                                                                                                                                                                        |                                       |                         |                      |                    |          |
| HARDNESS HB                                 | After hardening: 450HB                                                                                                                                                                                                                                               |                                       |                         |                      |                    |          |
| GAS ACC. EN ISO 14175                       |                                                                                                                                                                                                                                                                      |                                       |                         |                      |                    |          |



# CEWELD OA Mn14

OA MN14 1,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663402981 |

OA MN14 1,6MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663403018 |

OA MN14 2,8MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663403025 |