



CEWELD OA MnCr

TYPE

APPLICATIONS

PROPERTIES

CLASSIFICATION

SUITABLE FOR

APPROVALS

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

MECHANICAL PROPERTIES

REDRYING

HARDNESS HB

GAS ACC. EN ISO 14175

Tubular wire weldable without protective gas for rebuilding and buffer layers before hardfacing with extreme resistance to heavy impact loads.

Rebuilding heavy steel parts, buffer layers, rails, rails crossings, dredger teeth, blast furnace mantles etc..

Austenitic deposit with strain hardening properties and no limmits in the number of layers. The deposit is non magnetic and can not be flame cut.

EN ISO14700: T Fe9
DIN8555: MF 7-GF-250-KNP

Rebuilding, buffer layers, rails, rails crossings, dredger teeth, blast furnace mantles

PA

PB

PC

C	Si	Mn	Cr	Ni	Mo	V	Fe
0.45	0.4	15.7	14.8	1.25	0.55	0.25	Rem.

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded				240 HB

140°C / 24 hr

after hardening: 500HB



CEWELD OA MnCr

OA MNCR 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663402967

OA MNCR 2,8MM

Packaging	KG/unit	EanCode
BS-300	15	8720663402974