CEWELD®

# SACW MnCr

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| CATEGORY | SAW Submerged arc |
| TYPE | Flux-cored wire for submerged-arc welding. |
| APPLICATIONS | Building up worn out parts that suffer from wear combined with high impact, buffer layers ec. |
| PROPERTIES | 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. Extreme resistance to heavy impact loads.Th weld deposit offers fair corrosion resistance and has strain hardening properties. This alloy should be aplied at highest impact and pressure loads applications. Best to be used with welding flux FL 915 |
| CLASSIFICATION | AWS A 5.13: E FeMnCr<br>EN ISO 14700: E Fe9<br>DIN 8555: MF 7–250–KNP |
| SUITABLE FOR | Rebuilding rails, crossings, crushing hammers, dredger teeth, rollers, blast furnace, mantles, hardfacing manganese hard stee, buffer layersl etc.. |
| APPROVALS | CE approved |
| WELDING POSITIONS: |  |



## WELD DEPOSIT ANALYSIS WITH (FL 915J FLUX) (WEIGHT %)

| C | Mn | Si | Cr | Ni | Mo | V | Fe |
|---|---|---|---|---|---|---|---|
| 0.5 | 16.0 | 0.4 | 15 | 1.2 | 0.5 | 0.2 | Rem |

## MECHANICAL PROPERTIES

| Heat Treatment | $R_{P0,2}$ ($N/mm^2$) | Rm ($N/mm^2$) | A5 (%) | Impact Energy (J) ISO-V -20°C | Impact Energy (J) ISO-V -40°C | Hardness As welded | Hardness Strain hardening |
|---|---|---|---|---|---|---|---|
| AW | | | | | | 220-250 HB | ~500 HB |

AW: as welded

## WELDING PARAMETERS PACKING

| Welding Parameters | | | Packing | | |
|---|---|---|---|---|---|
| D (mm) | Voltage (V) | Current (A) DC+ | spool type | kg / spool / drum | kg / pallet |
| 1,6 | 20-26 | 160-260 | K-415 / Drum | 25 / 300 | |
| 2,0 | 22-26 | 240-280 | K-415 / Drum | 25 / 300 | |
| 2,4 | 24-27 | 280-340 | K-415 / Drum | 25 / 300 | |
| 2,8 | 25-28 | 320-400 | K-415 / Drum | 25 / 300 | |

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| REDRYING TEMPERATURE | 150°C / 24hr |