

CATEGORY	Metal spray wires	
TYPE	Solid drawn thermal spray wire for iron based coatings with low Si and Mn content	
APPLICATIONS	Machine parts, lockers, undersized axis, scratched surfaces, shafts, cylinder surfaces etc..	
PROPERTIES	Stable spray arc with wide parameter range, CEWELD® SP 10Mn can be applied with the electric arc and flame spray process offering remarkable bonding strength and excellent lubricating properties.	
CLASSIFICATION	EN ISO W.Nr.	14919: 5.1 1.0351
SUITABLE FOR	Flame spray, electric spray and high speed flame spray.	
APPROVALS	No Approvals Found	

WELDING POSITIONS:



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

Si	Mn	C
0.05	0.55	0.1

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R <sub>p0,2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)	Hardness Brinell Hardness
As Welded /1h				Avg. 160

WELDING PARAMETERS / PACKING

PARAMETERS	PARAMETERS	PARAMETERS	PARAMETERS	PARAMETERS	PACKING
D (MM)	VOLTAGE (V)	CURRENT (A)	DISTANCE	AIR PRESSURE	KG / SPOOL / DRUM
1,6	32	100-200	15-22 CM	60 PSI	15 - 18 KG BS-300 / H-420 20 KG / 250 KG

REDRYING TEMPERATURE	Not required
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GAS ACCORDING EN 14175