



# CEWELD OA Mn14

TYPE	Self-shielded and slag forming flux-cored wire for gas-shielded welding
ANWENDUNGEN	Welding parts of manganese steel that are exposed to impact and shock-like wear
EIGENSCHAFTEN	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.
KLASSIFIKATION	EN ISO 14700: T Fe9 DIN 8555: MF 7-GF-250-KNP
GEEIGNET FÜR	Rebuilding, buffer layers before hardfacing on steels with high carbon content, heavy impact loads, manganese steels

ZULASSUNGEN

SCHWEISSPOSITIONEN



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Ni	Fe
1	0.4	13.5	4.5	0.5	Rem.

MECHANISCHE GÜTEWERTE

Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Hardness
As Welded				230 HB

RÜCKTROCKNUNG 140°C / 24 hr

HARDNESS HB After hardening: 450HB

GAS ACC. EN ISO 14175



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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