



CEWELD AA M650

TYPE	Medium -alloyed seamless fluxcored wire on a C-Cr-Mo-W-V basis offering high hardness up to 500°C.							
ANWENDUNGEN	Recommended for parts subject to strong mineral abrasion and erosion that faces increased working temperatures up to 500°C.							
EIGENSCHAFTEN	Very good abrasion resistance in combination with impact even at higher temperatures up to 500°C. To much layers should be avoided, preheat is necessary to avoid cracking. A buffer layer with AA M690 or AA M37-42 is recommended in case of sensible base material or old hardfacing layers.							
KLASSIFIKATION	AWS EN ISO DIN W.Nr.		A 5.21: ERFe-8 14700: T Fe8 MSG 3-GF-60-GPZ ~1.2606					
GEEIGNET FÜR	HRc 58-62, Cement pumps, crusher bars, hammer and blooming table rolls, mineral and brick industry, stone crushers.							
ZULASSUNGEN								
SCHWEISSPOSITIONEN	PAPBPCPF							
TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%)	C	Si	Mn	Cr	Mo	V	Fe	W
	0.5	1.25	1.3	5.7	1.4	0.3	Rem.	1.3
MECHANISCHE GÜTEWERTE	Heat Treatment		R _{P0,2} (MPa)	R _m (MPa)		A5 (%)	Hardness	
	As Welded						59 HRc	
RÜCKTROCKNUNG	Not required							
GAS ACC. EN ISO 14175	M21							



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AA M650 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663424198