



# CEWELD MA HSS

**TYPE** Solid drawn hardfacing alloy based on a High Speed Steel (HSS) weld deposit.

**APPLICATIONS** Cutting edges, tool making, gouges, turning chisel, broaches, schredder knives, scissors etc.

**PROPERTIES** Extreme hard and heat resistant alloy that offers excellent cutting properties when cutting steel cables, bars, wooden bars etc. The CEWELD MA HSS is only machinable by grinding.

**Soft annealed** 770°C - 840°C/2 - 4h = 27 HRc  
**Hardened** 1190°C - 1230°C/air,Oil,Hot bath = 60 HRc  
**Tempered two times** 530°C - 560°C = 62 HRc

**CLASSIFICATION**

AWS	A 5.21: ERFc-8
EN ISO	14700: S Fe3
DIN	8555: MSG 4-UM-60-65-ST
W.Nr.	1.3348
F-nr	71

**SUITABLE FOR** 57-62 HRc hardfacing alloy for steel cutting knives, scissors, HSS, high speed tool steel, 1.3348, molds, edges and repairs on ; X85WDCV06-04-02 ; V6Mo5Cr4V2 ; HS 6-5-2 ; M2, J438B; X85WDCV06-04-02 ; BM2 ; SKH 51 ; R 6 M 5

**APPROVALS**

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)**

C	Mn	Cr	Ni	Mo	V	Fe	W	Si
1	0.3	4	3.5	8	2	Rem.	1.8	0.3

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Hardness
As Welded				60 HRc

**REDRYING** Not required

**GAS ACC. EN ISO 14175** M21



# CEWELD MA HSS

MA HSS 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663401755

MA HSS 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663401762