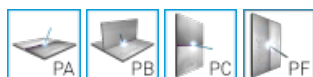


CEWELD E DUR 49

TYPE	Rutile Fe, Cr, Co and Mo based electrode
APPLICATIONS	Hardfacing of forging presses, hot piercing dies, stretching rolls, pinch rolls, hot strip mill table rolls and back-up rolls
PROPRIÉTÉS	Rutile Fe, Cr, Co and Mo based elektotrode with high hot wear resistance, tensile strenght and a high resistance against sliding wear of metallic objects.It has a good retention of hardness up to 650°C and is non scaling up to 900° C thermo shock resistant and resistant to sudden changes of temperature.Work hardening. Not crack sensible.The number of layers can be done as necessary. The deposit can be additionally treated with cutting tools.
CLASSIFICATION	EN ISO 14700: E Fe3
CONVIENT POUR	1.2311 40CrMnMo 7 1.2343 X38CrMoV 5 1 1.2344 X40CrMoV 5 1 1.2365 X32CrMoV 3 3 1.2367 X38CrMoV 5 3 1.2606 X37CrMoW 5 1 1.2713 55NiCrMoV 6 1.2714 56NiCrMoV 7

AGRÉMENTS

POSITIONS DE SOUDAGE



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

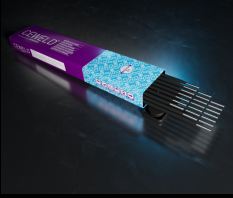
C	Si	Mn	Cr	Mo	Fe	Co
0.15	0.6	0.6	14	2.3	Rem.	13

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded				48 HRc

ETUVAGE 300°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD E DUR 49

E DUR 49 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	3	8720663402141