



# CEWELD E DUR MnCr

<b>TYPE</b>	Basic Hardfacing electrode with high impact and wear resistance								
<b>APPLICATIONS</b>	Basic electrode for rebuilding and joining cold straining Mn steels or rebuilding parts that are subject to high impact and rolling wear.								
<b>PROPRIÉTÉS</b>	There is no limit for the number of layers that can be applied in case of rebuilding but heat input should be kept low (as for Mn steel, interpass temperature should be kept < 250 °C).								
<b>CLASSIFICATION</b>	<table border="0"> <tr> <td>AWS</td> <td>A 5.13: E FeMnCr</td> </tr> <tr> <td>EN ISO</td> <td>14700: E Fe9</td> </tr> <tr> <td>DIN</td> <td>8555: E 7-UM-250-K</td> </tr> <tr> <td>F-nr</td> <td>71</td> </tr> </table>	AWS	A 5.13: E FeMnCr	EN ISO	14700: E Fe9	DIN	8555: E 7-UM-250-K	F-nr	71
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EN ISO	14700: E Fe9								
DIN	8555: E 7-UM-250-K								
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<b>CONVIENT POUR</b>	Rebuilding and joining cold straining Mn steels or rebuilding parts that are subject to high impact and rolling wear. Breaker teeth, Crushers, Hammers, Crossings, Rails.								

**AGRÉMENTS**

**POSITIONS DE SOUDAGE**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

C	Mn	Cr	Fe	Si
0.75	17.5	14	Rem.	0.4

**PROPRIÉTÉS MÉCANIQUES**

Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A5 (%)	Hardness
As Welded				270 HB

**ETUVAGE** 300°C / 2 hr

**GAS ACC. EN ISO 14175**



# CEWELD E DUR MnCr

E DUR MNCR 2,5 X 350MM	Packaging	KG/unit	EanCode
	Can	2,5	8720663401496
E DUR MNCR 3,2 X 350MM	Packaging	KG/unit	EanCode
	Can	2,5	8720663401502
E DUR MNCR 4,0 X 450MM	Packaging	KG/unit	EanCode
	Can	3,0	8720663401519