CEWELD AA M650

certilas® THE FILLER METAL SPECIALIST

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	A 5.21: ERFe-8
EN ISO	14700: T Fe8
DIN	MSG 3-GF-60-GPZ
W.Nr.	~1.2606

GEEIGNET FÜR

HRc 58-62, Cement pumps, crusher bars, hammer and blooming table rolls, mineral and brick industry, stone crushers.

ZULASSUNGEN

SCHWEISSPOSITIONEN

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)	Rm (MPa)	A5 (%)	Hardness
As Welded				59 HRc

RÜCKTROCKNUNG

Not required

GAS ACC. EN ISO 14175

M21

CEWELD AA M650

AA M650 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663424198