



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	Mo	V	Fe	W	Si
1	0.3	4	8	2	Rem.	1.8	0.3

MECHANICAL PROPERTIES

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	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