CEWELD AA B57-62

certilas® THE FILLER METAL SPECIALIST

TYPE	Seamless medium alloyed basic fluxcored wire with slag for hardfacing using Ar-CO2 mix
ANWENDUNGEN	Rebuilding and cladding parts against strong abrasion and heavy impact.
EIGENSCHAFTEN	Due to the high resistance to cracking and toughness, all weld metal requires no buffer layer except on materials considered critical. In this situation CEWELD® ER 100 S-G is recommended. Suited for wear parts subject to heavy impact and shock. The interpass temperature should be maximum 250°C. The weld metal is machinable by special carbide tools, hardening is possible. The maximum hardness is dependent on the base metal and is achieved in the first layer. For material considered critical to cracking we advise to buffer with one layer CEWELD® AA B460.
KLASSIFIKATION	EN ISO 14700: T Fe4
GEEIGNET FÜR	55-62 HRc hardfacing alloy against heavy impact and shock, bucket, loaders, crusher jaws, crusher cones, pumps, sand, snow scratchers, stone cutting tools etc.
ZULASSUNGEN	
SCHWEISSPOSITIONEN	

TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%)

C	Si	Mn	Cr	Mo
0.5	0.6	1.5	6	0.5

MECHANISCHE GÜTEWERTE

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded				60 HRc

RÜCKTROCKNUNG	Not required
GAS ACC. EN ISO 14175	M21