



# CEWELD SAS 550-VW

**TYPE** Sintered hardfacing strip for rebuilding and overlay applications.

**APPLICATIONS** Rebuilding wornout parts such as screws, chrusher hammers, drive tumblers, chrusher rolls, dredging parts etc...

**PROPRIÉTÉS** The weld deposit offers excellent wear resistance against shocks and abrasion as well. Already the first layer gives excellent results even on mild steel due to the low dilution of the electro slag process. Due to the low dilution with the base metal a hardness exceeding 50 HRc can be achieved already in the first layer. Multiple layers can be applied to obtain full hardness at the final layer. Flux to be used FL 830 ESH

**CLASSIFICATION** EN ISO 14700: C Fe8

**CONVIENT POUR** 52-58 HRc electro slag and / or submerged arc strip for hardfacing against schock and wear, Rebuilding wornout parts such as screws, chrusher hammers, drive tumblers, chrusher rolls, dredging parts etc..  
For ESW welding [FL 830 ESHC](#) should be used as welding flux to obtain the results mentioned in this datasheet.

**AGRÉMENTS**

**POSITIONS DE SOUDAGE**



**ANALYSE CHIMIQUE  
TYPIQUE DU MÉTAL DE  
SOUDURE (%)**

| C    | Mn  | Cr | Ni   | Mo  | V    | W   |
|------|-----|----|------|-----|------|-----|
| 0.33 | 2.8 | 7  | 0.25 | 1.7 | 0.25 | 1.8 |

**PROPRIÉTÉS MÉCANIQUES**

| Heat Treatment | R <sub>P0.2</sub> (MPa) | R <sub>m</sub> (MPa) | A5 (%) | Hardness |
|----------------|-------------------------|----------------------|--------|----------|
| As Welded      |                         |                      |        | 56 HRc   |

**ETUVAGE** Not required

**GAS ACC. EN ISO 14175**