



# CEWELD OA Mn14

**TYPE** Self-shielded and slag forming flux-cored wire for gas-shielded welding

**APPLICATIONS** Welding parts of manganese steel that are exposed to impact and shock-like wear

**PROPERTIES** Austenitic deposit with strain hardening properties and no limits in the number of layers. The deposit is non magnetic and can not be flame cut.  
Hardness HB: After workhardening: 450HB

**CLASSIFICATION** EN ISO 14700: T Fe9  
DIN 8555: MF 7-GF-250-KNP

**SUITABLE FOR** Rebuilding, buffer layers before hardfacing on steels with high carbon content, heavy impact loads, manganese steels

**APPROVALS**

**WELDING POSITIONS**



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

C	Si	Mn	Cr	Ni	Fe
1	0.4	13.5	4.5	0.5	Rem.

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Hardness
As Welded				230 HB

**REDRYING** 140°C / 24 hr

**HARDNESS HB** After hardening: 450HB

**GAS ACC.** EN ISO 14175



# CEWELD OA Mn14

OA MN14 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663402981

OA MN14 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663403018

OA MN14 2,8MM

Packaging	KG/unit	EanCode
BS-300	15	8720663403025