



# CEWELD AA SS 50

**TYPE** C, Cr, V-, W alloyed cored wire for hardfacing applications. (1.2564)

**APPLICATIONS** Rebuilding wornout parts that faces wear and impact combined with increased working temperatures. Hot dies, dies, punches, hammer dies, drawing rings Forging dies, mandrels slab shears, hot cuts, etc.

**PROPERTIES** Machinable ,Heat resistant weld deposit with excelent wear resistance. The weld deposit can be heat treated to offer maximum service protection. Tempered 560° C ~ 52 HRc Tempered 450° C ~ 49 HRc Tempered 350° C ~ 48 HRc Soft annealed 250 HB

**CLASSIFICATION** EN ISO 14700: T Fe3  
 DIN MSG 3–GF-45-T  
 W.Nr. 1.2567

**SUITABLE FOR** **45-52 HRc**  
 1.2567, 1.2365, 1.2713, 1.2714, 1.2581  
 30WCrV17 2, 32CrMoV12-283, 55NiCrMoV6, 55NiCrMoV7, X30WCrV9-3

**APPROVALS**

**WELDING POSITIONS**



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

C	Si	Mn	Cr	V	W	Fe
0.3	0.75	0.8	2.5	0.6	4.5	Rem.

**MECHANICAL PROPERTIES**

Heat Treatment	RP0,2 (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded				47 HRc
580°C±15°C 1h				53 HRc

**REDRYING** 140°C / 2 hr

Hardening : 1060° C-1120° C°, hot bath, compressed air. Tempering : approx. 3 h / temperature depending on desired working hardness. Soft annealing : 2 - 4 h at 800° C -840° C / furnace cooling

**GAS ACC. EN ISO 14175** M13