



CEWELD SS 6356 (40 HRc)

TYPE Cobalt alloyed age hardenable hardfacing alloy for Mig and Tig welding.

APPLICATIONS High alloyed, age-hardenable alloy for high wear resistant clad layers combined with galling and high working temperatures.

PROPERTIES The weld deposit is, in the as-welded condition machinable, and the subsequent artificial aging optimises the resistance to hot wear and alternating temperatures.

CLASSIFICATION EN ISO 14700: S Fe5

SUITABLE FOR Age-hardenable alloy for high wear resistant clad layers on cold and hot working tools. Repair, preventive maintenance and production of highly stressed cold and hot working tools, such as punching dies, cold and hot cutting knives, Al-dies cast moulds, cold forging dies, drawing, stamping- and chamfering tools.

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

| C | Ni | Co | Mo | Mn | Si | Fe |
|------|----|----|----|-----|-----|------|
| 0.03 | 17 | 10 | 4 | 0.3 | 0.8 | Rem. |

MECHANICAL PROPERTIES

| Heat Treatment | R _{P0.2} (MPa) | R _m (MPa) | A5 (%) | Hardness |
|----------------|-------------------------|----------------------|--------|----------|
| As Welded | 885 | 990 | | 39 HRc |

REDRYING Not required

GAS ACC. EN ISO 14175 I1, M13, M12