



# CEWELD E DUR MnCr

**TYPE** Basic-coated strain hardening high recovery stick electrode for hardfacing.( Fe 9 )

**APPLICATIONS** CEWELD® E DUR MnCr is a basic electrode for rebuilding and joining cold straining Mn steels or rebuilding parts that are subject to high impact and rolling wear.  
Such as: Excavator teeth, beating arm, dredger bolts, crusher jaws and cones, sand blasting and shot peening devices;  
Railway systems: crossing frogs and four-way pieces.

**PROPERTIES** CEWELD® E DUR MnCr has no limit to the number of layers that can be applied in the event of rebuilding, but the heat input should be kept low (as with Mn steel, the interpass temperature should be < 250 °C).  
Hardness: 250 [HB] up to 450 [HB] workhardened  
Recovery: 140%

**CLASSIFICATION**

AWS	A 5.13: E FeMnCr
EN ISO	14700: E Fe9
DIN	8555: E 7-UM-250-K
F-nr	71

**SUITABLE FOR** Rebuilding and joining cold straining Mn steels or rebuilding parts that are subject to high impact and rolling wear. Breaker teeth, Crushers, Hammers, Crossings, Rails.

**APPROVALS**

**WELDING POSITIONS**



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Mn	Cr	Fe	Si
	0.75	17.5	14	Rem.	0.4

MECHANICAL PROPERTIES	Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Hardness
	As Welded				270 HB

**REDRYING** 300°C / 2 hr

**GAS ACC.** EN ISO 14175



# CEWELD E DUR MnCr

E DUR MNCR 2,5 X 350MM	Packaging	KG/unit	EanCode
	Can	2,5	8720663401496
E DUR MNCR 3,2 X 350MM	Packaging	KG/unit	EanCode
	Can	2,5	8720663401502
E DUR MNCR 4,0 X 450MM	Packaging	KG/unit	EanCode
	Can	3,0	8720663401519