



CEWELD MA HSS

TYPE Solid drawn hardfacing alloy based on a High Speed Steel (HSS) weld deposit.

APPLICATIONS Cutting edges, tool making, gouges, turning chisel, broaches, schredder knives, scissors etc.

PROPERTIES Extreme hard and heat resistant alloy that offers excellent cutting properties when cutting steel cables, bars, wooden bars etc. The CEWELD MA HSS is only machinable by grinding.

Soft annealed 770°C - 840°C/2 - 4h = 27 HRc
Hardened 1190°C - 1230°C/air,Oil,Hot bath = 60 HRc
Tempered two times 530°C - 560°C = 62 HRc

CLASSIFICATION

| | |
|--------|-------------------------|
| AWS | A 5.21: ERFc-8 |
| EN ISO | 14700: S Fe3 |
| DIN | 8555: MSG 4-UM-60-65-ST |
| W.Nr. | 1.3348 |
| F-nr | 71 |

SUITABLE FOR 57-62 HRc hardfacing alloy for steel cutting knives, scissors, HSS, high speed tool steel, 1.3348, molds, edges and repairs on ; X85WDCV06-04-02 ; V6Mo5Cr4V2 ; HS 6-5-2 ; M2, J438B; X85WDCV06-04-02 ; BM2 ; SKH 51 ; R 6 M 5

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

| C | Mn | Cr | Ni | Mo | V | Fe | W | Si |
|---|-----|----|-----|----|---|------|-----|-----|
| 1 | 0.3 | 4 | 3.5 | 8 | 2 | Rem. | 1.8 | 0.3 |

MECHANICAL PROPERTIES

| Heat Treatment | R _{P0,2} (MPa) | R _m (MPa) | A ₅ (%) | Hardness |
|----------------|-------------------------|----------------------|--------------------|----------|
| As Welded | | | | 60 HRc |

REDRYING Not required

GAS ACC. EN ISO 14175 M21



CEWELD MA HSS

MA HSS 1,0MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| BS-300 | 15 | 8720663401755 |

MA HSS 1,2MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| BS-300 | 15 | 8720663401762 |