

# CEWELD E DUR 49

**TYPE** Rutile Fe, Cr, Co and Mo based electrode

**APPLICATIONS** Hardfacing of forging presses, hot piercing dies, stretching rolls, pinch rolls, hot strip mill table rolls and back-up rolls

**PROPRIÉTÉS** Rutile Fe, Cr, Co and Mo based elektotrode with high hot wear resistance, tensile strenght and a high resistance against sliding wear of metallic objects. It has a good retention of hardness up to 650°C and is non scaling up to 900° C thermo shock resistant and resistant to sudden changes of temperature. Work hardening. Not crack sensible. The number of layers can be done as necessary. The deposit can be additionally treated with cutting tools.

**CLASSIFICATION** EN ISO 14700: E Fe3

**CONVIENT POUR**

- 1.2311 40CrMnMo 7
- 1.2343 X38CrMoV 5 1
- 1.2344 X40CrMoV 5 1
- 1.2365 X32CrMoV 3 3
- 1.2367 X38CrMoV 5 3
- 1.2606 X37CrMoW 5 1
- 1.2713 55NiCrMoV 6
- 1.2714 56NiCrMoV 7

**AGRÉMENTS**

**POSITIONS DE SOUDAGE**



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

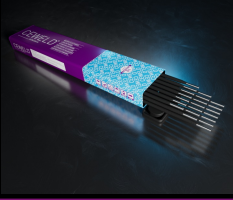
| C    | Si  | Mn  | Cr | Mo  | Fe   | Co |
|------|-----|-----|----|-----|------|----|
| 0.15 | 0.6 | 0.6 | 14 | 2.3 | Rem. | 13 |

**PROPRIÉTÉS MÉCANIQUES**

| Heat Treatment | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Hardness |
|----------------|-------------------------|----------------------|--------------------|----------|
| As Welded      |                         |                      |                    | 48 HRc   |

**ETUVAGE** 300°C / 2 hr

**GAS ACC. EN ISO 14175**



# CEWELD E DUR 49

E DUR 49 3,2 X 350MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Can       | 3       | 8720663402141 |