

## SACW MnCr

**CATEGORY** SAW Arc Submerged

**TYPE** Flux-cored wire for submerged-arc welding.

**APPLICATIONS** Building up worn out parts that suffer from wear combined with high impact, buffer layers ec.

**PROPERTIES** Austenitic deposit with strain hardening properties and no limits in the number of layers. The deposit is non magnetic and can not be flame cut. Extreme resistance to heavy impact loads. The weld deposit offers fair corrosion resistance and has strain hardening properties. This alloy should be applied at highest impact and pressure loads applications. Best to be used with welding flux [FL 915](#)

**CLASSIFICATION**

AWS	A 5.13: E FeMnCr
EN ISO	14700: E Fe9
DIN	8555: MF 7-250-KNP

**SUITABLE FOR** Rebuilding rails, crossings, crushing hammers, dredger teeth, rollers, blast furnace, mantles, hardfacing manganese hard steel, buffer layers etc..

**APPROVALS** CE approved

**WELDING POSITIONS:**



**WELD DEPOSIT ANALYSIS WITH (FL 915) FLUX) (WEIGHT %)**

C	Mn	Si	Cr	Ni	Mo	V	Fe
0.5	16.0	0.4	15	1.2	0.5	0.2	Rem

**MECHANICAL PROPERTIES**

Heat Treatment	Rp0,2 (N/mm <sup>2</sup> )	Rm (N/mm <sup>2</sup> )	A5 (%)	Impact Energy (J) ISO-V		Hardness	
				-20°C	-40°C	As welded	Strain hardening
AW						220-250 HB	~500 HB

AW: as welded

**WELDING PARAMETERS PACKING**

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A) DC+	spool type	kg / spool / drum	kg / pallet
1,6	20-26	160-260	K-415 / Drum	25 / 300	
2,0	22-26	240-280	K-415 / Drum	25 / 300	
2,4	24-27	280-340	K-415 / Drum	25 / 300	
2,8	25-28	320-400	K-415 / Drum	25 / 300	

**REDRYING TEMPERATURE** 150°C / 24hr