
POWDER FOR SURFACE WELDING

Number PD-5256
Issue 1-13.04.2016

AMPERWELD[®] CCA4

CCA4 is a Fe based atomized alloy with an exceptionally high amount finely distributed, precipitated carbides. Welded overlays are of high hardness and high wear resistance, paired with good tribological properties.

Chemical Formula	FeVCrCWMoMnSi
Description of Product	Gas Atomized
Particle Sizes Available	150 / 53 µm 212 / 53 µm

Chemical Characteristics

(Mass fraction in % [cg/g]; ppm [µg/g])

V	16.5 - 17.1	%
Cr	12.0 - 13.0	%
C	3.8 - 4.0	%
W	1.1 - 1.5	%
Mo	0.6 - 1.0	%
Mn	0.3 - 0.7	%
Si	0.4 - 1.1	%
Fe	balance	

Physical Characteristics

(Particle Size Distribution and Tolerances above / below max. in %)

Particle Size Distribution¹⁾

+ 150 µm	max	5	%
- 53 µm	max	5	%
+ 212 µm	max	5	%
- 53 µm	max	5	%

1) ROTAP Screening per ASTM B 214

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Packaging	Standard Packaging: 5 kg in 2.5 l PE bottle, 6 bottles (30 kg) in one cardboard box.
Storage and Handling	Storage and handling are subject to the rules and regulations in the country of use.
Hazards identification in Advertising (REGULATION (EC) No 1272/2008 Article 48)	None.
Documentation	An inspection document in accordance with EN 10204 is supplied with every shipment.
Remarks	Always mix well before using. Other particle sizes on request.

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