



CEWELD OA 60-68B

TYPE High-alloy metal cored wire for hardfacing using Ar-CO2 mix, also without shielding gas.

ANWENDUNGEN Chromium free hardfacing wire for extreme abrasion. Single layer on mild steel reaches a hardness > 60HRc.

EIGENSCHAFTEN The hardfacing contains sufficient special carbides formed with boron and therefore has excellent resistance to abrasion from sand and minerals. The weld metal is machinable only by grinding. Stringer bead technique is recommended. The hard surfacing contains check cracks, but this does not impair wear resistance.

KLASSIFIKATION EN ISO 14700: T Fe13
DIN 8555: MF 4-GF-65-G

GEEIGNET FÜR Cr-free Hardfacing alloy against extreme abrasion like agricultural equipment, sand, snow scratchers, stone cutting tools and mining equipment, Highway construction equipment and conveyor chains, mixing paddles, cement pumps components, etc. 2 layer hardness : 61-68HRc.

ZULASSUNGEN

SCHWEISSPOSITIONEN



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

| C | Si | Mn | Cr | Ni | Mo | Fe | B |
|-----|-----|-----|-----|-----|-----|------|-----|
| 0.5 | 0.3 | 1.1 | 0.3 | 1.5 | 1.5 | Rem. | 4.2 |

MECHANISCHE GÜTEWERTE

| Heat Treatment | R _{P0,2} (MPa) | R _m (MPa) | A ₅ (%) | Hardness |
|----------------|-------------------------|----------------------|--------------------|----------|
| As Welded | | | | 65 HRc |

RÜCKTROCKNUNG 140°C / 24 hr

HARDNESS HRC first layer: 61-64HRc, second layer 62-68HRc

GAS ACC. EN ISO 14175



CEWELD OA 60-68B

OA 60-68B 1,2MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| BS-300 | 16 | 8720663403674 |

OA 60-68B 1,6MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| BS-300 | 16 | 8720663403681 |