CEWELD OA 68 Nb

certilas® THE FILLER METAL SPECIALIST

TYPE

High C-, Cr-, Mo, Nb-, V-, alloyed flux-cored wire electrode which forms extremely hard carbides for extremely hard deposits on parts subject to excessively heavy abrasive wear weldable without protective gas.

APPLICATIONS

Hardfacing wornout parts that requires maximum hardness in just 1 or 2 layers combined with highest wear resistance.

PROPERTIES

Extreme good wear resistance even at increased working temperatures. More than 1, maximum 2 layers should not be deposited. A Buffer layer with OA 4370, OA MnCr or ER 100 is recommended.

CLASSIFICATION

EN ISO	14700: T Fe16
DIN	8555: MF 10-GF-70-G

SUITABLE FOR

67-69 HRc hardfacing alloy, for fire gratings, sintering plants, augers and blast furnace bells ,gravel washing equipment, clinker crushers, stone recycling, screw conveyors, sintering lines, mixer blades, wear plates, earth moving equipment etc.

APPROVALS

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Mo	Nb	V	B
4	1.2	0.25	18	0.3	11	0.45	1.8

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded				69 HRc

REDRYING

140°C / 24 hr

GAS ACC. EN ISO 14175

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OA 68 NB 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663403810