



CEWELD OA WC2 Ni

TYPE	Nickel based flux cored wire for hardfacing containing a high amount of tungsten carbides.										
ANWENDUNGEN	This Ni-based alloy provides an excellent corrosion resistance combined with extreme abrasion resistance. OA WC2 (Ni) can be applied on all sorts of steels except on cast iron or Mn-steel. This alloy is the most wear resistant type in most hardfacing applications. In case of very fine dust abrasion It might happen that the matrix will be washed out and loses the imbedded Tungsten carbides, in this case another hardfacing product should be considered.										
EIGENSCHAFTEN	2400 HV nickel based corrosion resistant hardfacing alloy containing 60% tungsten carbides. OA WC2 (Ni) has excellent flow and wetting characteristics. Multi-layer deposits are possible and worn parts can be rebuild without removing the old material. Crushed cast carbide will guarantee a long life for several wear applications. Best to be used with shielding gas M21 (80%Ar/20%Co2) 12 - 18 litres per minute.										
KLASSIFIKATION	EN ISO	14700: T Ni20									
	DIN	8555: MF 21-GF-55-CGTZ									
GEEIGNET FÜR	Rebuilding of stabilisers and other oilfield tools where maximum protection is required. Also for augers, impellers, mixer plates in the brick and clay industry and on decanter screws or hardfacing deep drilling equipment.										
ZULASSUNGEN											
SCHWEISSPOSITIONEN											
TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%)	C	Si	Ni	Cr	B	WSC					
	0.4	2.5	Rem.	2.7	1.7	48					
MECHANISCHE GÜTEWERTE	Heat Treatment	$R_{P0.2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness						
	As Welded				2360 HV						
RÜCKTROCKNUNG	140°C / 24 hr										
HARDNESS / COMPOSITION	Matrix: 50-54 HRc Carbides: ~2360 HV0.1										
GAS ACC. EN ISO 14175	M21, M12, M13, M20										



CEWELD OA WC2 Ni

OA WC2 NI 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663403865

OA WC2 NI 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663403889

OA WC2 NI 2,4MM

Packaging	KG/unit	EanCode
BS-300	15	8720663403902