



CEWELD OA 64

TYPE	Fluxcored wire for hardfacing, weldable without protective gas.							
ANWENDUNGEN	Rebuilding wornout parts or protecting new machine parts to increase life that suffer from grinding wear combined with increased temperatures.							
EIGENSCHAFTEN	High C-, Cr-, Mo-, Nb-, V-, W-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. Extreme good wear resistance even at higher temperatures up to 650°C. More than 1 or 2 layers should not be deposited. Hardness reduction at 400°C app. 4%, at 650°C app. 10%. A Buffer layer with OA 4370 or OA MnCr is recommended in case of old layers or critical base metals. Equivalent in SMAW: Dur 64							
KLASSIFIKATION	EN ISO	14700: T Fe16						
	DIN	8555: MF 10-GF-65-GZ						
GEEIGNET FÜR	For fire gratings, sintering plants, augers and blast furnace bells ,gravel washing equipment, sugar mill hammer and knives, clinker crushers, coal mill rollers, screw conveyors, sintering lines, mixer blades etc.							
ZULASSUNGEN								
SCHWEISSPOSITIONEN	PAPBPC							
TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%)	C	Si	Mn	Cr	Mo	Nb	V	W
	5	1.4	0.4	21	6.5	6.5	0.9	2.1
MECHANISCHE GÜTEWERTE	Heat Treatment		R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness		
	As Welded					64 HRc		
RÜCKTROCKNUNG	140°C / 24 hr							
GAS ACC. EN ISO 14175								



CEWELD OA 64

OA 64 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663403742

OA 64 2,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663403759

OA 64 2,4MM

Packaging	KG/unit	EanCode
BS-300	15	8720663403766

OA 64 2,8MM

Packaging	KG/unit	EanCode
BS-300	15	8720663403773