



CEWELD OA 63 VWB

TYPE	High-alloyed tubular wire on a C-Cr-V-W-B carbide basis for extreme hard deposits on parts subject to strong mineral abrasion, weldable without protective gas.												
ANWENDUNGEN	Hardfacing and rebuilding parts that faces severe aggressive abrasion in cement industry, mining and stone crushing.												
EIGENSCHAFTEN	Extreme abrasion resistant with improved impact properties when combined with OA 400 as buffer layer. Due to the combination Cr-V-W-B carbides the deposit structure contains very fine particles that results in excellent wear resistance against heavy abrasion. Usually the maximum number of layers is 2 till 3 but when using a special stringer build up technique with release cracks, up to 15 layers is possible.												
KLASSIFIKATION	EN ISO	14700: T Fe15											
	DIN	8555: MF 10-GF-65-G											
GEEIGNET FÜR	Nihard IV segmented roller and parts without buffer layer, slurry pumps, loaders, sand and earth moving equipment such as buckets and teeth, dredge buckets, crushing equipment, rockwool rolls and brick industry, cement rollers, table segments, wear plates etc.												
ZULASSUNGEN													
SCHWEISSPOSITIONEN													
TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%)	C	Si	Mn	Cr	V	W	B						
	5	1.1	0.8	25	6	2	0.5						
MECHANISCHE GÜTEWERTE	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Hardness								
	As Welded				63 HRc								
RÜCKTROCKNUNG	140°C / 24 hr												

GAS ACC. EN ISO 14175