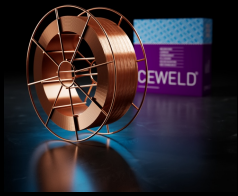


# CEWELD OA 60-68B

|                                                    |                                                                                                                                                                                                                                                                                                                                                         |                    |                         |                      |        |          |      |     |
|----------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------|-------------------------|----------------------|--------|----------|------|-----|
| 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. 3 layer hardness : up to 70 HRC.                                                                      |                    |                         |                      |        |          |      |     |
| ZULASSUNGEN                                        |                                                                                                                                                                                                                                                                                                                                                         |                    |                         |                      |        |          |      |     |
| SCHWEISSPOSITIONEN                                 | <div>PAPBPCPF</div> |                    |                         |                      |        |          |      |     |
| TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%) | 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 <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A5 (%) | 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 |