



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.

APPLICATIONS Hardfacing and rebuilding parts that faces severe aggressive abrasion in cement industry, mining and stone crushing.

PROPRIÉTÉS 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.

CLASSIFICATION EN ISO 14700: T Fe15
DIN 8555: MF 10-GF-65-G

CONVIENT POUR 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.

AGRÉMENTS

POSITIONS DE SOUDAGE



ANALYSE CHIMIQUE TIPIQUE DU MÉTAL DE SOUDURE (%)

C	Si	Mn	Cr	V	W	B
5	1.1	0.8	25	6	2	0.5

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	$R_{P0,2}$ (MPa)	R_m (MPa)	A5 (%)	Hardness
As Welded				63 HRc

ETUVAGE

140°C / 24 hr

GAS ACC. EN ISO 14175