



CEWELD OA 60-68B

TYPE	High-alloy metal cored wire for hardfacing using Ar-CO2 mix, also without shielding gas.		
APPLICATIONS	Chromium free hardfacing wire for extreme abrasion. Single layer on mild steel reaches a hardness > 60HRC.		
PROPRIÉTÉS	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.		
CLASSIFICATION	EN ISO DIN	14700: T Fe13 8555: MF 4-GF-65-G	
CONVIENT POUR	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.		

AGRÉMENTS

POSITIONS DE SOUDAGE



ANALYSE CHIMIQUE TYPIQUE DU MÉTAL DE SOUDURE (%)

C	Si	Mn	Cr	Ni	Mo	Fe	B
0.5	0.3	1.1	0.3	1.5	1.5	Rem.	4.2

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A5 (%)	Hardness
As Welded				65 HRC

ETUVAGE

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