




CEWELD AA 66B

TYPE	High alloyed fluxcored wire for hardfacing against extreme abrasion.												
ANWENDUNGEN	Rebuilding wornout parts or protecting new machine parts to increase life that suffer from extreme abrasive wear												
EIGENSCHAFTEN	High C-Cr-Nb, B-alloyed flux-cored wire electrode which forms extremely hard complex carbides for extremely wear resistant deposits on parts subject to excessively heavy abrasive wear weldable under mixed gas. Extreme good wear resistance due to excellent first layer hardness properties. More than 1 or 2 layers should not be deposited. A Buffer layer with OA 4370 or OA MnCr is recommended in case of old layers or critical base metals..												
KLASSIFIKATION	EN ISO 14700: T Fe16												
GEEIGNET FÜR	64-68 HRc Hardfacing wire used in mining, agriculture and steel mills, conveyor chains, agriculture, construction, mixer blades, paddles, cement pumps with excellent abrasion and wear resistance against sand and minerals												
ZULASSUNGEN													
SCHWEISSPOSITIONEN													
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td style="width: 16.6%;">C</td> <td style="width: 16.6%;">Si</td> <td style="width: 16.6%;">Mn</td> <td style="width: 16.6%;">Ni</td> <td style="width: 16.6%;">Nb</td> <td style="width: 16.6%;">B</td> </tr> <tr> <td>2.5</td> <td>0.6</td> <td>2</td> <td>11.5</td> <td>5</td> <td>2</td> </tr> </table>	C	Si	Mn	Ni	Nb	B	2.5	0.6	2	11.5	5	2
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MECHANISCHE GÜTEWERTE	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td style="width: 33%;">Heat Treatment</td> <td style="width: 16.5%;">R_{P0,2} (MPa)</td> <td style="width: 16.5%;">R_m (MPa)</td> <td style="width: 16.5%;">A₅ (%)</td> <td style="width: 16.5%;">Hardness</td> </tr> <tr> <td>As Welded</td> <td></td> <td></td> <td></td> <td>66 HRc</td> </tr> </table>	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness	As Welded				66 HRc		
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RÜCKTROCKNUNG	Not required												
GAS ACC. EN ISO 14175	M21												