



CEWELD AA 66 Safe

TYPE Cr-free Hardfacing Cored wire. (64-68 HRc)

APPLICATIONS **CEWELD® AA 66 Safe** is a **chromium-free** hardfacing wire designed for extreme abrasion resistance. Typical applications include excavator cutters, mixer blades, conveyor augers, concrete pumps, and gravel and sand processing equipment.

PROPERTIES The hardfacing deposit of **CEWELD® AA 66 Safe** contains a high density of special boron-carbides, providing exceptional resistance to severe abrasion from sand and minerals. The weld metal is machinable only by grinding, and the use of a stringer bead technique is highly recommended. While the hardfacing layer naturally develops check cracks, this does not impair its wear resistance; these cracks effectively reduce residual stresses within the layer and prevent it from delaminating from the base material. A single layer applied to mild steel achieves a hardness of over 60 HRc, while a maximum of two layers can be applied to reach a hardness of up to 70 HRc.

CLASSIFICATION EN ISO 14700: T Fe13

SUITABLE FOR ~70 HRc

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Ni	B
0.6	1.1	2	2.8	4.8

MECHANICAL PROPERTIES

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A5 (%)	Hardness
As Welded				66 HRc

REDRYING Not required

GAS ACC. EN ISO 14175 M12



CEWELD AA 66 Safe

AA 66 SAFE 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720682052235

AA 66 SAFE 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720682052242