



CEWELD OA WC2 Ni

TYPE Fluxcored hardfacing welding wire with Nickel matrix and 60% Tungsten carbides (WC2)

APPLICATIONS This Ni-based alloy provides an excellent corrosion resistance combined with extreme abrasion resistance. OA WC2 (Ni) can be applied on all sorts of steels except on cast iron or Mn-steel. This alloy is the most wear resistant type in most hardfacing applications. In case of very fine dust abrasion It might happen that the matrix will be washed out and loses the imbedded Tungsten carbides, in this case another hardfacing product should be considered.

PROPERTIES 2400 HV nickel based corrosion resistant hardfacing alloy containing 60% tungsten carbides. OA WC2 (Ni) has excellent flow and wetting characteristics. Multi-layer deposits are possible and worn parts can be rebuild without removing the old material. Crushed cast carbide will guaranty a long life for several wear applications. Best to be used with shielding gas M13 (Argon with 1% Oxygen) approx. 15 litres per minute.

CLASSIFICATION EN ISO 14700: T Ni20
DIN 8555: MF 21-GF-55-CGTZ

SUITABLE FOR Rebuilding of stabilisers and other oilfield tools where maximum protection is required. Also for augers, impellers, mixer plates in the brick and clay industry and on decanter screws or hardfacing deep drilling equipment.

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Ni	TFC	Cr	B
0.4	2.5	Rem.	44	2.7	1.7

MECHANICAL PROPERTIES

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A5 (%)	Hardness
As Welded				2400 HV

REDRYING 140°C / 24 hr

HARDNESS / COMPOSITION Matrix: 55HRc (± 56%) Carbides: 2400HV (FTC ±44%)

GAS ACC. EN ISO 14175



CEWELD OA WC2 Ni

OA WC2 NI 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663403865

OA WC2 NI 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663403889

OA WC2 NI 2,4MM

Packaging	KG/unit	EanCode
BS-300	15	8720663403902