



CEWELD OA 54 L

TYPE High-alloyed tubular wire on a C-Cr. carbide basis for abrasive wear resistance in combination with corrosion.

APPLICATIONS Rebuilding and or protecting wear parts against extreme abrasion in combination with corrosion, with low impact.

PROPERTIES Can be welded crack free by preheating approximately 450°C and keep that also as interpass temperature. Slowly cooling down, for example in an oven.

CLASSIFICATION EN ISO 14700: T ZFe14
DIN 8555: MF 10-60-CGT

SUITABLE FOR 56-59 HRc hardfacing alloy, Mixing peddles, Press screws, Kneading machine, screw conveyors, pumps etc.

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

| C | Si | Mn | Cr | Fe |
|-----|-----|-----|----|------|
| 3.7 | 1.2 | 0.2 | 32 | Rem. |

MECHANICAL PROPERTIES

| Heat Treatment | R _{p0,2} (MPa) | R _m (MPa) | A ₅ (%) | Hardness |
|----------------|-------------------------|----------------------|--------------------|----------|
| As Welded | | | | 57 HRc |

REDRYING 140°C / 24 hr

GAS ACC. EN ISO 14175