



CEWELD OA 550-VW

TYPE Medium -alloyed tubular wire on a C-Cr-Mo-W basis for high hardness up to 550°C.

APPLICATIONS Recommended for parts subject to strong abrasion and erosion with impact. Excavator teeth, excavator cutting edges, gravel pumps, screw conveyors, blow bars, crusher rollers, road construction, shredder plants, Turasse, rock processing, scrap grabs

PROPERTIES Very good abrasion resistance in combination with impact even at higher temperatures up to 550°C. Too much layers should be avoided, preheat is necessary to avoid cracking. A buffer layer with OA 4370 or OA MnCr is recommended in case of sensible basematerial or old layers. Weldable without protective gas.

CLASSIFICATION EN ISO 14700: T Fe6
DIN 8555: MF 6-60-PT

SUITABLE FOR HRc 55-58, Cement pumps, crusher bars, hammer and blooming table rolls, mineral and brick industry.

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Mo	V	Fe	W
0.55	0.9	2.8	7	1.6	1.8	Rem.	0.9

MECHANICAL PROPERTIES

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Hardness
As Welded				55 HRc

REDRYING 140°C / 24 hr

GAS ACC. EN ISO 14175



CEWELD OA 550-VW

OA 550-VW 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663403315

OA 550-VW 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663403490

OA 550-VW 2,8MM

Packaging	KG/unit	EanCode
BS-300	15	8720663403414