




CEWELD OA 62-66B

TYPE	High alloyed seamless flux cored wire for hardfacing against extreme abrasion.												
APPLICATIONS	Rebuilding wornout parts or protecting new machine parts to increase life that suffer from extreme abrasive wear												
PROPERTIES	High C-, Cr-, B-alloyed flux-cored wire electrode which forms extremely hard carbides for extremely hard deposits on parts subject to excessively heavy abrasive wear weldable with and without protective 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 CEWELD® OA 4370 or CEWELD® OA MnCr is recommended in case of old layers or critical base metals..												
CLASSIFICATION	EN ISO 14700: T Fe15												
SUITABLE FOR	62-66 HRc Hardfacing alloy 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.												
APPROVALS													
WELDING POSITIONS													
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%;">Cr</td> <td style="width: 16.6%;">B</td> <td style="width: 16.6%;">Fe</td> </tr> <tr> <td>5</td> <td>1.6</td> <td>1.6</td> <td>27</td> <td>0.45</td> <td>Rem.</td> </tr> </table>	C	Si	Mn	Cr	B	Fe	5	1.6	1.6	27	0.45	Rem.
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MECHANICAL PROPERTIES	<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>62 HRc</td> </tr> </table>	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness	As Welded				62 HRc		
Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness									
As Welded				62 HRc									
REDRYING	Not required												
HARDNESS HRC	first layer: 58-62HRc, second layer: 62-65HRc												
GAS ACC. EN ISO 14175													



CEWELD OA 62-66B

OA 62-66B 1,6MM

Packaging	KG/unit	EanCode
BS-300	16	8720663403698