



CEWELD OA 68 Nb

TYPE High C-, Cr-, Mo, Nb-, V-, alloyed flux-cored wire electrode which forms extremely hard carbides for extremely hard deposits on parts subject to excessively heavy abrasive wear weldable without protective gas.

APPLICATIONS Hardfacing wornout parts that requires maximum hardness in just 1 or 2 layers combined with highest wear resistance.

PROPRIÉTÉS Extreme good wear resistance even at increased working temperatures. More than 1, maximum 2 layers should not be deposited. A Buffer layer with OA 4370, OA MnCr or ER 100 is recommended.

CLASSIFICATION EN ISO 14700: T Fe16
DIN 8555: MF 10-GF-70-G

CONVIENT POUR 67-69 HRc hardfacing alloy, for fire gratings, sintering plants, augers and blast furnace bells ,gravel washing equipment, clinker crushers, stone recycling, screw conveyors, sintering lines, mixer blades, wear plates, earth moving equipment etc.

AGRÉMENTS

POSITIONS DE SOUDAGE



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

| C | Si | Mn | Cr | Mo | Nb | V | B |
|---|-----|------|----|-----|----|------|-----|
| 4 | 1.2 | 0.25 | 18 | 0.3 | 11 | 0.45 | 1.8 |

PROPRIÉTÉS MÉCANIQUES

| Heat Treatment | R _{P0,2} (MPa) | R _m (MPa) | A5 (%) | Hardness |
|----------------|-------------------------|----------------------|--------|----------|
| As Welded | | | | 69 HRc |

ETUVAGE 140°C / 24 hr

GAS ACC. EN ISO 14175



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OA 68 NB 1,6MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| BS-300 | 15 | 8720663403810 |