



CEWELD OA 67 NiB

TYPE Fluxcored wire for hardfacing with exceptional hardness.

APPLICATIONS Hardfacing wire against heavy wear with excellent abrasion resistance against sand and minerals.

PROPRIÉTÉS Extreme good wear resistance even with thin coating thickness due to a high amount of Borium carbides. A extreme high hardness is already achieved in the first layer. The weld deposit will show release cracks to offer better bonding strenght with the base metal. More than 1 layer should not be deposited. A Buffer layer is recommended in case of sensitive base material or old unknown layers. OA 67 NiBo can be welded without using protective gas (open arc) but is also available as Gas shielded version.

CLASSIFICATION EN ISO 14700: T Fe13
DIN 8555: MF 2-GF-70-G

CONVIENT POUR Mining and steel mills, conveyor chains, agriculture, construction, mixer blades, paddles, cement pumps, screw conveyers, sintering lines, earth moving equipment etc.

AGRÉMENTS

POSITIONS DE SOUDAGE



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Ni	B
0.5	1.2	1.8	2.9	4.8

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded				67 HRc

ETUVAGE 140°C / 24 hr

GAS ACC. EN ISO 14175