



CEWELD OA 60-70B

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 excelent first layer hardness properties. More than 1 or 2 layers should not be deposited. A Buffer layer with OA 4370 or OA MnCr is recommended in case of old layers or critical base metals..					
CLASSIFICATION	EN ISO	14700: T ZFe13				
	DIN	8555: MF 10-GF-70-G				
SUITABLE FOR	60-70 HRc Hardfacing wire used in mining, agriculture and steel mills, conveyor chains, agriculture, construction, mixer blades, paddles, cement pumps with excelent abrasion and wear resistance against sand and minerals					
APPROVALS						
WELDING POSITIONS	 PA  PB  PC  PF					
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	Cr	Fe	B
	1.8	0.6	0.8	8.2	Rem.	4.2
MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Hardness	
	As Welded				64 HRc	
REDRYING	Not required					
HARDNESS HRC	first layer: 60-64HRc, second layer 65-70HRc					
GAS ACC. EN ISO 14175						



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OA 60-70B 1,6MM

Packaging	KG/unit	EanCode
BS-300	16	8720663403704