

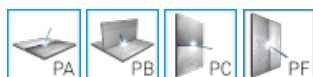


# CEWELD OA 60-68B

|                |                                                                                                                                                                                                                                                                                                                             |                                     |  |
|----------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------|--|
| TYPE           | High-alloy metal cored wire for hardfacing using Ar-CO2 mix, also without shielding gas.                                                                                                                                                                                                                                    |                                     |  |
| APPLICATIONS   | Chromium free hardfacing wire for extreme abrasion. Single layer on mild steel reaches a hardness > 60HRC.                                                                                                                                                                                                                  |                                     |  |
| PROPRIÉTÉS     | The hardfacing contains sufficient special carbides formed with boron and therefore has excellent resistance to abrasion from sand and minerals. The weld metal is machinable only by grinding. Stringer bead technique is recommended. The hard surfacing contains check cracks, but this does not impair wear resistance. |                                     |  |
| CLASSIFICATION | EN ISO<br>DIN                                                                                                                                                                                                                                                                                                               | 14700: T Fe13<br>8555: MF 4-GF-65-G |  |
| CONVIENT POUR  | Cr-free Hardfacing alloy against extreme abrasion like agricultural equipment, sand, snow scratchers, stone cutting tools and mining equipment, Highway construction equipment and conveyor chains, mixing paddles, cement pumps components, etc. 3 layer hardness : up to 70 HRC.                                          |                                     |  |

## AGRÉMENTS

## POSITIONS DE SOUDAGE



## ANALYSE CHIMIQUE TYPIQUE DU MÉTAL DE SOUDURE (%)

| C   | Si  | Mn  | Cr  | Ni  | Mo  | Fe   | B   |
|-----|-----|-----|-----|-----|-----|------|-----|
| 0.5 | 0.3 | 1.1 | 0.3 | 1.5 | 1.5 | Rem. | 4.2 |

## PROPRIÉTÉS MÉCANIQUES

| Heat Treatment | R <sub>P0.2</sub><br>(MPa) | R <sub>m</sub><br>(MPa) | A5<br>(%) | Hardness |
|----------------|----------------------------|-------------------------|-----------|----------|
| As Welded      |                            |                         |           | 65 HRC   |

ETUVAGE 140°C / 24 hr

HARDNESS HRC first layer: 61-64HRC, second layer 62-68HRC

GAS ACC. EN ISO 14175



# CEWELD OA 60-68B

OA 60-68B 1,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 16      | 8720663403674 |

OA 60-68B 1,6MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 16      | 8720663403681 |