



# CEWELD OA 70 Na

|                                                        |                                                                                                                                                                                                                                                                                                                                                                |    |                |                            |    |                         |     |           |          |   |
|--------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----|----------------|----------------------------|----|-------------------------|-----|-----------|----------|---|
| TYPE                                                   | High-alloy tubular wire based on a complex carbide alloy wire for hardfacing against extreme abrasion.                                                                                                                                                                                                                                                         |    |                |                            |    |                         |     |           |          |   |
| APPLICATIONS                                           | CEWELD® OA 70 Na is based on a nanotechnology concept of the alloy CCrMoNbWB. It forms special carbides for the wear protection coating of exhaust fans, mixer blades, kiln mixers, furnace chutes, scrapers, screw conveyors and other equipment that is subject to heavy abrasion and erosion at elevated temperature.<br>(Best weldable with M21 mixed gas) |    |                |                            |    |                         |     |           |          |   |
| PROPRIÉTÉS                                             | Resistant to heavy abrasion and erosion caused by impact. Retains its hardness at elevated temperatures of up to 750°C. Can withstand thermal cycling. Low coefficient of friction without lubrication.<br><b>64 - 66 HRc (first layer)</b><br><b>67 - 72 HRc (max. second layer)</b>                                                                          |    |                |                            |    |                         |     |           |          |   |
| CLASSIFICATION                                         | EN ISO                                                                                                                                                                                                                                                                                                                                                         |    | 14700: T Z Fe8 |                            |    |                         |     |           |          |   |
| CONVIENT POUR                                          | <b>65-75 HRc Hardfacing</b> 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.                                                                                                                            |    |                |                            |    |                         |     |           |          |   |
| AGRÉMENTS                                              |                                                                                                                                                                                                                                                                                                                                                                |    |                |                            |    |                         |     |           |          |   |
| POSITIONS DE SOUDAGE                                   | <div>PAPBPC</div>                                                                                     |    |                |                            |    |                         |     |           |          |   |
| ANALYSE CHIMIQUE<br>TYPIQUE DU MÉTAL DE<br>SOUDURE (%) | C                                                                                                                                                                                                                                                                                                                                                              | Si | Mn             | Cr                         | Mo | Nb                      | V   | Fe        | W        | B |
|                                                        | 2.5                                                                                                                                                                                                                                                                                                                                                            | 2  | 1              | 9.5                        | 4  | 7                       | 2.5 | Rem.      | 4.5      | 3 |
| PROPRIÉTÉS MÉCANIQUES                                  | Heat Treatment                                                                                                                                                                                                                                                                                                                                                 |    |                | R <sub>p0,2</sub><br>(MPa) |    | R <sub>m</sub><br>(MPa) |     | A5<br>(%) | Hardness |   |
|                                                        | As Welded                                                                                                                                                                                                                                                                                                                                                      |    |                |                            |    |                         |     |           | 70 HRc   |   |
| ETUVAGE                                                | Not required                                                                                                                                                                                                                                                                                                                                                   |    |                |                            |    |                         |     |           |          |   |
| GAS ACC. EN ISO 14175                                  | M21                                                                                                                                                                                                                                                                                                                                                            |    |                |                            |    |                         |     |           |          |   |