



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



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

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)	A ₅ (%)	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