



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 excellent 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 excellent abrasion and wear resistance against sand and minerals

APPROVALS

WELDING POSITIONS



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)	A ₅ (%)	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