



CEWELD OA 612

TYPE	High alloyed fluxcored wire for hardfacing.
APPLICATIONS	Bucket teeth, conveyors, cruscher hammers, coal mine cutters, mixer blades, mixer blades etc.
PROPRIÉTÉS	This alloy offers very good resistance against general abrasion and heavy shock, all weld metal requires no buffer layer except on materials considered critical or in case of old hardfacing layers. In this Situation OA 4370, ER 100 S1 or OA MnCr is recommended. Suited for wear parts subject to strong impact, abrasion and shock. In critical cases the interpass temperature should be kept at 270°C for the best results. The weld metal is only machinable by grinding. Weldable without gas (open arc). (Also weldable under M21 mixed gas)
CLASSIFICATION	EN ISO 14700: T Fe8 DIN 8555: MF 6-GF-55-PR
CONVIENT POUR	54 HRc hardfacing alloy for wear resistant overlays, sand pumps, valve seats, dredger equipment, bucket teeth, stone crushing, hammers etc.

AGRÉMENTS

POSITIONS DE SOUDAGE



ANALYSE CHIMIQUE TYPIQUE DU MÉTAL DE SOUDURE (%)

C	Si	Mn	Cr	Fe
0.5	1	1.2	12.5	Rem.

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A5 (%)	Hardness
As Welded				55 HRc

ETUVAGE

140°C / 24 hr

GAS ACC. EN ISO 14175