



CEWELD OA 60-68B

TYPE	High-alloy metal cored wire for hardfacing using Ar-CO2 mix, also without shielding gas.							
ANWENDUNGEN	Chromium free hardfacing wire for extreme abrasion. Single layer on mild steel reaches a hardness > 60HRc.							
EIGENSCHAFTEN	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.							
KLASSIFIKATION	EN ISO	14700: T Fe13						
	DIN	8555: MF 4-GF-65-G						
GEEIGNET FÜR	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.							
ZULASSUNGEN								
SCHWEISSPOSITIONEN	   							
TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%)	C	Si	Mn	Cr	Ni	Mo	Fe	B
	0.5	0.3	1.1	0.3	1.5	1.5	Rem.	4.2
MECHANISCHE GÜTEWERTE	Heat Treatment		R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Hardness		
	As Welded					65 HRc		
RÜCKTROCKNUNG	140°C / 24 hr							
HARDNESS HRC	first layer: 61-64HRc, second layer 62-68HRc							
GAS ACC. EN ISO 14175								



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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