



CEWELD OA WC2 Ni

TYPE	Fluxcored hardfacing welding wire with Nickel-Boron-Silicon matrix up to 60% Tungsten carbides (FTC)					
APPLICATIONS	CEWELD® OA WC2 Ni can be applied to all types of steel except cast iron and Mn steel. The main areas of application are: Repair and hardfacing of ferritic and austenitic steel tools and machine parts (cast steel) It was specially developed for semi-automatic and fully automatic welding on tool joints and stabilizers in the petroleum industry.					
PROPERTIES	CEWELD® OA WC2 Ni is a cored wire with a NiCrBSi matrix alloy in which tungsten carbides are embedded. It was developed to protect surfaces from extreme abrasive wear in combination with corrosion attacks. The welding alloy consists of approximately 60% WC ₂ and 35–40% Ni-Cr-B-Si matrix. The alloy has a low melting range between 900 and 1050 °C (1652–1922 °F) and is characterized by a self-flowing property that produces a smooth and clean surface. The matrix is highly resistant to acids, bases, alkalis, and other corrosive media. Matrix: 50-54 HRc Carbides: ~2360 HV0.1					
CLASSIFICATION	EN ISO	14700: T Ni20				
	DIN	8555: MF 21-GF-55-CGTZ				
SUITABLE FOR	Rebuilding of stabilisers and other oilfield tools where maximum protection is required. Also for augers, impellers, mixer plates in the brick and clay industry and on decanter screws or hardfacing deep drilling equipment.					
APPROVALS						
WELDING POSITIONS						
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Ni	Cr	B	WSC
	0.4	2.5	Rem.	2.7	1.7	55
MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness	
	As Welded				2360 HV	
REDRYING	140°C / 24 hr					
HARDNESS / COMPOSITION	Matrix: 50-54 HRc Carbides: ~2360 HV0.1					
GAS ACC. EN ISO 14175	M21, M12, M13, M20					



CEWELD OA WC2 Ni

OA WC2 Ni 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663403865

OA WC2 Ni 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663403889

OA WC2 Ni 2,4MM

Packaging	KG/unit	EanCode
BS-300	15	8720663403902