



# CEWELD OA SS 60

**TYPE** High-Mo alloyed flux cored wire on a „High Speed steel basis“ (HSS) for extreme hard deposits on parts subject to strong impact and high pressure, weldable without protective gas.

**APPLICATIONS** Rebuilding wornout parts that faces wear and impact combined with increased working temperatures. (Excellent alloy for making cutting tools out of mild steel)

**PROPRIÉTÉS** High wear resistance and similar structure as High speed tool steels. The deposit gives already a very good hardness in the first layer. A buffer layer with OA 4370 or OA MnCr is recommended in case of sensible basematerial or old Hardface-layers.

**CLASSIFICATION** EN ISO 14700: T Fe4

**CONVIENT POUR** 59-62 HRc hardfacing alloy for cutting edges, wood shredders, knives, recycling equipment, HSS, High speed tool steel alloy. Cutting edges on knives and share blades, pumps, mixer blades, wood shredders etc.. (Excellent alloy for making cutting tools out of mild steel)

**AGRÉMENTS**

**POSITIONS DE SOUDAGE**



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

| C   | Mn  | Si  | Cr  | W | Mo | V   | Fe   |
|-----|-----|-----|-----|---|----|-----|------|
| 0.8 | 0.4 | 0.6 | 4.5 | 2 | 8  | 1.5 | Rem. |

**PROPRIÉTÉS MÉCANIQUES**

| Heat Treatment | R <sub>P0.2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Hardness |
|----------------|-------------------------|----------------------|--------------------|----------|
| As Welded      |                         |                      |                    | 59 HRc   |

**ETUVAGE** 140°C / 24 hr

**GAS ACC. EN ISO 14175**



# CEWELD OA SS 60

OA SS 60 1,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663403926 |