CEWELD®

OA 56 Nb

CATEGORY	FCAW Flux-Cored
TYPE	High-alloyed tubular wire on a C-Cr-Nb-W-V carbide basis against schock and abrasion.
APPLICATIONS	Rebuilding and hardfacing wornout parts that faces heavy shock and abrasion at the same time.
PROPERTIES	Very good wear resistance against abrasion combined with impact. The deposit gives already a very good hardness in the first layer thank to the Nb carbides. The choice for the buffer layer is depending on the base metal and not always necessary.
CLASSIFICATION	AWS A 5.21: EN ISO 14700: T Fe8 DIN 8555: MF 6-55-GP
SUITABLE FOR	55-57 HRc hardfacing alloy against shocks and mineral wear, Cement rollers and crushers, Mineral and brick crushing industry, Screw conveyers, carbidge recycling etc.
APPROVALS	CE approved
WELDING POSITIONS:	

WELD METAL ANALYSIS %

C	Mn	Si	Cr	Nb	V	W
1.40	.1.30	0.70	6.50	8.0	1.0	1.2

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (N/mm²)	Rm (N/mm²)	A5 (%)	Impact Energy (J) ISO-V -20°C	-40°C	-60°C	Hardness HRc / HV
AW							55-57 HRc

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing	
D (mm)	Voltage (V)	Current (A)	spooling type	kg / spool / drum
1.2	18-24	100-220	S-300 / Coil B-450 / Drum	15 / 30 / 300
1.6	20-26	160-260	S-300 / Coil B-450 / Drum	15 / 30 / 300
2.0	22-26	240-280	S-300 / Coil B-450 / Drum	15 / 30 / 300
2.4	24-27	280-340	S-300 / Coil B-450 / Drum	15 / 30 / 300
2.8	25-28	320-400	S-300 / Coil B-450 / Drum	15 / 30 / 300

REDRYING TEMPERATURE	150°C / 24hr.
STICK OUT	25-40 mm