CEWELD®

OA 68 Nb

CATEGORY	FCAW Flux-Cored
TYPE	High C-, Cr-, Mo, Nb-, V-, alloyed flux-cored wire electrode which forms extremely hard carbides for extremely hard deposits on parts subject to excessively heavy abrasive wear weldable without protective gas.
APPLICATIONS	Hardfacing wornout parts that requires maximum hardness in just 1 or 2 layers combined with highest wear resistance.
PROPERTIES	Extreme good wear resistance even at increased working temperatures. More than 1, maximum 2 layers should not be deposited. A Buffer layer with OA 4370, OA MnCr or ER 100 is recommended.
CLASSIFICATION	AWS A 5.21: EN ISO 14700: T Fe 16 DIN 8555: MF-10-70-G
SUITABLE FOR	67-69 HRc hardfacing alloy, for fire gratings, sintering plants, augers and blast furnace bells ,gravel washing equipment, clinker crushers, stone recycling, screw conveyors, sintering lines, mixer blades, wear plates, earth moving equipment etc.
APPROVALS	CE approved
WELDING POSITIONS:	

WELD METAL ANALYSIS %

C	Mn	Si	Cr	Nb	Mo	V	Fe
4.0	0.6	1.1	19.0	13.0	0.30	0.4	rem

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
AW							67-69

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing	
D (mm)	Voltage (V)	Current (A)	spools type	kg / 6pack
1.2	18-25	110-180	S-300 / Drum	15 / 250
1.6	20-26	140-280	S-300 / Drum	15 / 250
2.0	22-27	220-280	S-300 / Drum	15 / 250
2.4	26-28	260-320	S-300 / Drum	15 / 250

REDRYING TEMPERATURE	150°C / 24hr.