CEWELD®

SPA 68T

CATEGORY	Metal spray wires
TYPE	High-alloyed tubular wire on a C-Cr-B- carbide basis for extreme hard and heat resistant deposits on parts subject to severe mineral abrasion.
APPLICATIONS	Cement industry, sand winning, mining, agriculture, steel mills etc.
PROPERTIES	High wear resistance with ledeburitic structure as by C-Cr-B. Carbide deposits. The deposit gives a extreme high hardness, all spray metal requires no buffer layer except on materials considered critical. In this Situation Ceweld SP NiAl is recommended. Suited for wear parts subject to extreme heavy abrasion and corrosion. Due to the high chromium content this alloy offers high heat resistance as well. The spray deposit is only machinable by grinding.
CLASSIFICATION	AWS A 5.21: EFeCr-A1 EN ISO 14700: TFE-14 DIN 8555: MF 10-GF-70-GTRZ
SUITABLE FOR	High-alloyed tubular wire for metal spray on a C-Cr-B- carbide basis for extreme hard and heat resistant deposits on parts subject to severe mineral abrasion. Applications: Cement industry, pumps, mixer blades, fans, sleeves, mixers, shear blades etc.
WELDING POSITIONS:	

WELD METAL ANALYSIS %

C	Mn	Si	Cr	B
5.0	0.8	0.8	38	2.0

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (N/mm^2)	Rm (N/mm^2)	A5 (%)	Impact Energy (J) ISO-V -20°C	-40°C	-60°C	Hardness HRc
as sprayed							62-68

Hardness fully depend on the spray parameters

WELDING PARAMETERS PACKING

Welding Parameters					Packing
D (mm)	Voltage (V)	Current (A)	Distance	Air pressure	kg / spool
1.6	32	100-200	15-22 cm	60 psi	15 / K-300
2.4	34	150-280	16-24 cm	60 psi	15 / K-300
3.2	36	220-400	18-26 cm	60 psi	25 / K-415

REDRYING TEMPERATURE	150`C / 24hr
NOTE	Other spool types and dimensions are also available