



CEWELD OA 615

TYPE Medium -alloyed tubular wire on a C-Cr-Mo-W-V basis for high hardness up to 550°C.

APPLICATIONS Recommended for parts subject to strong mineral abrasion and erosion.

PROPERTIES Very good abrasion resistance in combination with impact even at higher temperatures up to 550°C. To much layers should be avoided, preheat is necessary to avoid cracking. A buffer layer with OA 4370 or OA MnCr is recommended in case of sensible base material or old layers. Weldable without protective gas.

CLASSIFICATION EN ISO 14700: T Fe6

SUITABLE FOR Cement pumps, Crusher bars, Hammer and Blooming table rolls, Mineral and Brick industry.

APPROVALS No Approvals Found

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Mo	V	Fe	W
0.55	1	2.7	6.7	1.6	1.5	Rem.	1

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	Hardness Rockwell C
As Welded /				Avg. 60

REDRYING TEMPERATURE 140°C / 24 hr

GAS ACCORDING EN 14175



CEWELD OA 615

OA 615 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663403384

OA 615 1,6MM

Type	KG/unit	EANCode
BS-300	15	8720663403391