CEWELD OA 54 L

certilas® THE FILLER METAL SPECIALIST

TYPE

High-alloyed tubular wire on a C-Cr. carbide basis for abrasive wear resistance in combination with corrosion.

APPLICATIONS

CEWELD ® OA 54 L is a high C-Cr alloyed flux-cored wire. It is suitable for applications that are subject to heavy wear from mineral substances and corrosion.
Its main applications are in the following areas: corrosion-resistant kneaders, bushings, pumps, mixer blades, screw conveyors, press screws, oil screws.

PROPERTIES

CEWELD ® OA 54 L should be applied in 2-3 layers with a maximum thickness of 8-10 mm.
Crack-free application of the weld metal is possible with appropriate heat management. It should be preheated to approx. 450°C, and the temperature should be maintained during the welding process.
Care should be taken to ensure slow cooling, using oven cooling if necessary.
Cracks in the weld metal can only be avoided with high preheating.

CLASSIFICATION

EN ISO	14700: T ZFe14
DIN	8555: MF 10-60-CGT

SUITABLE FOR

56-59 HRc hardfacing alloy, Mixing peddles, Press screws, Kneading machine, screw conveyors, pumps etc.

APPROVALS

No Approvals Found

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Mo	Fe
3.7	1.2	0.2	32	0.2	Rem.

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)		Hardness Rockwell C
As Welded /					Avg. 57

REDRYING TEMPERATURE

140°C / 24 hr

GAS ACCORDING EN 14175

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OA 54 L 1,6MM

Type	KG/unit	EANCode
BS-300	15	8720682051849