



CEWELD OA 68 Nb

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 EN ISO 14700: T Fe16
DIN 8555: MF 10-GF-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 No Approvals Found

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Mo	Nb	V	B
4	1.2	0.25	18	0.3	11	0.45	1.8

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	Hardness Rockwell C
As Welded /				Avg. 69

REDRYING TEMPERATURE 140°C / 24 hr

GAS ACCORDING EN 14175



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OA 68 NB 1,6MM

Type	KG/unit	EANCode
BS-300	15	8720663403810